

HOSTAFORM® M25AE

Extrusion grade targeted for shapes free of center porosity.

Hostaform® M25AE is a special grade of acetal copolymer targeted for extrusion shapes (rod, bar, plate, etc.) free of center porosity in large diameters and thicknesses.

Chemical abbreviation according to ISO 1043-1: POM

Rheological properties

Melt volume-flow rate	2.5 cm ³ /10min	ISO 1133
Melt mass-flow rate	2.9 g/10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Melt mass-flow rate, Temperature	190 °C	
Melt mass-flow rate, Load	2.16 kg	

Typical mechanical properties

Tensile Modulus	2400 MPa	ISO 527-1/-2
Yield stress, 50mm/min	61 MPa	ISO 527-1/-2
Yield strain, 50mm/min	11 %	ISO 527-1/-2
Flexural Modulus	2400 MPa	ISO 178
Charpy impact strength, 23°C	250 ^[P] kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	250 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5 kJ/m ²	ISO 179/1eA

[P]: Partial Break

Thermal properties

Melting temperature, 10°C/min	163 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	91 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	160 °C	ISO 306
Coeff. of linear therm. expansion, parallel	110 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 E-6/K	ISO 11359-1/-2

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183

Injection

Drying Temperature	100 - 120 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Max. mould temperature	80 - 120 °C
Back pressure	4 MPa
Injection speed	slow



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Additional information

Profile extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Sheet extrusion

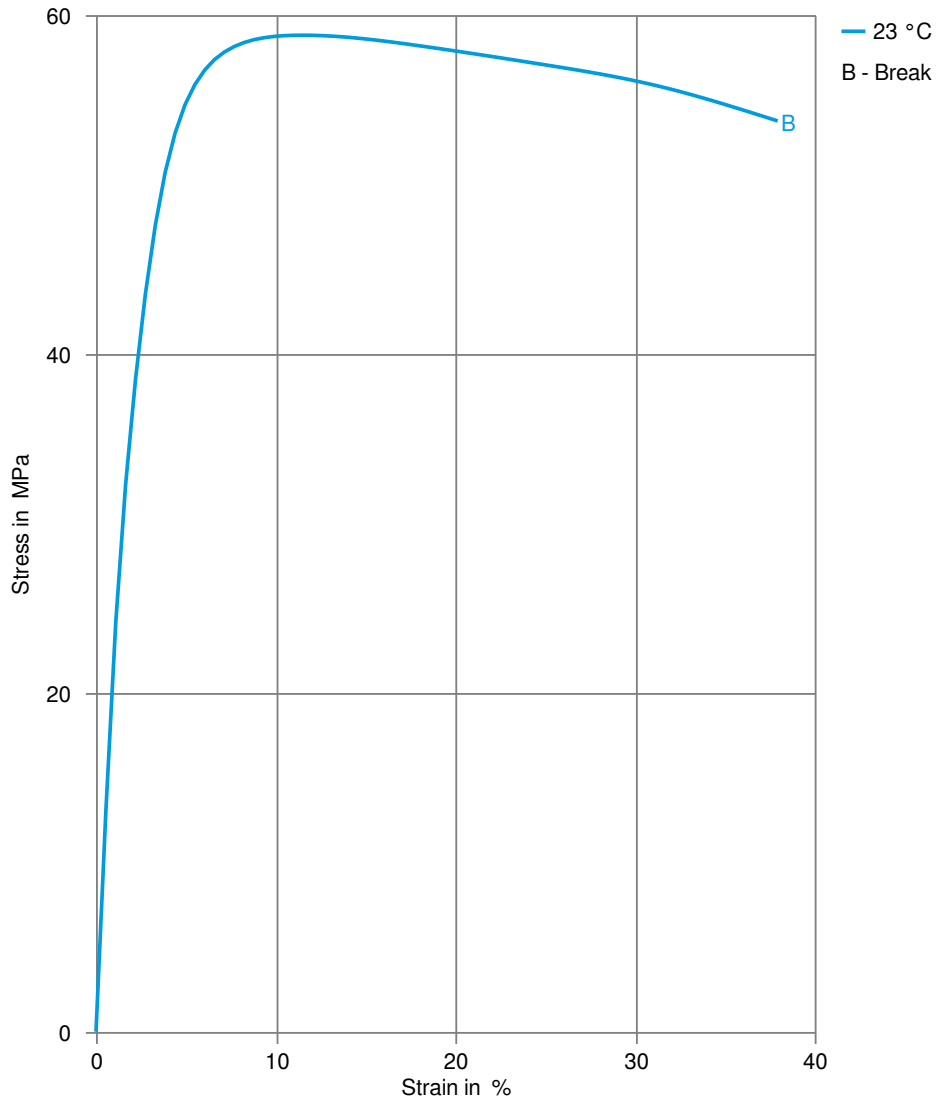
Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C



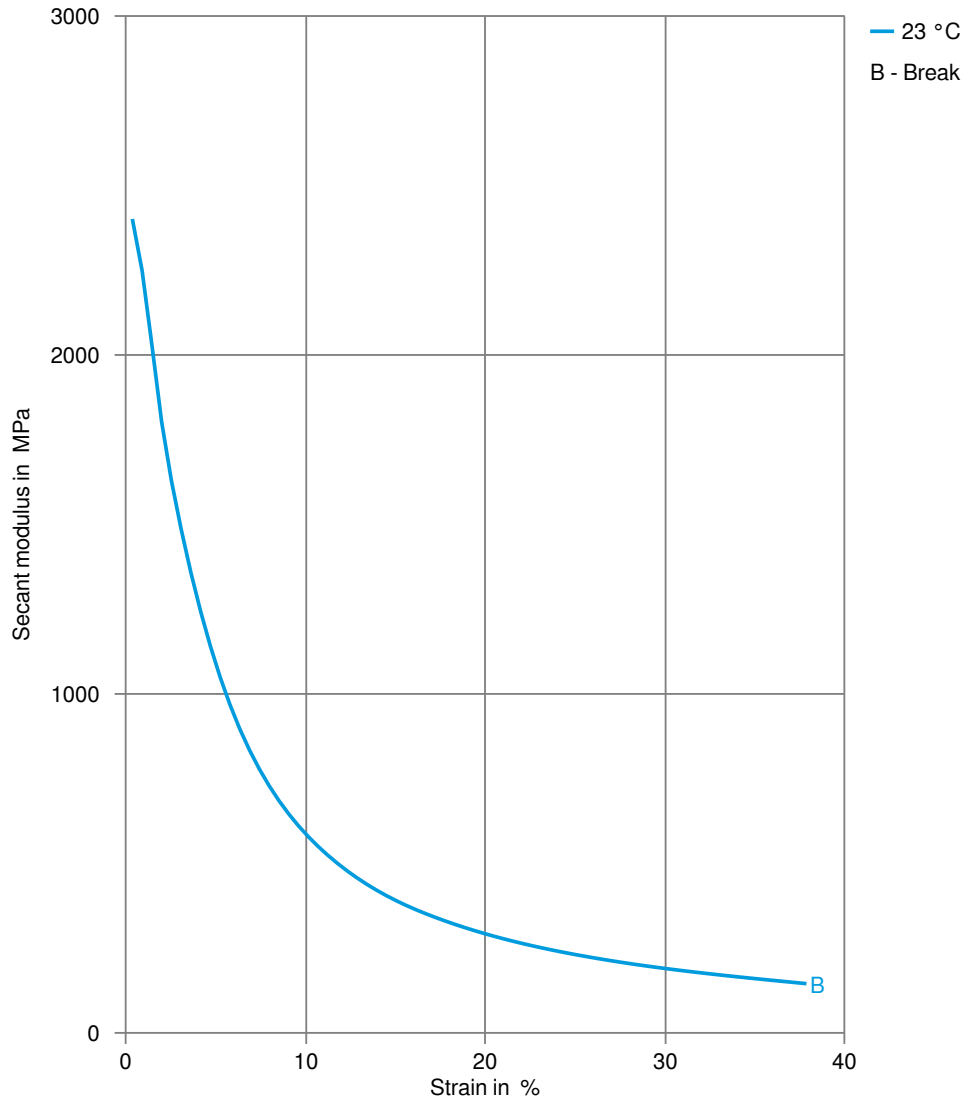
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Stress-strain



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Secant modulus-strain



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Processing Texts

Pre-drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

