

HOSTAFORM® S 4000P CT - POM

Experimental Grade. Please contact your Celanese representative for further information.

Description

Chemical abbreviation according to ISO 1043-1: POM-HI POM copolymer, modified Hostaform® S 4000P CT is an impact-modified acetal copolymer with high flowability for demanding injection molding applications. Hostaform® S 4000P CT has a significantly higher MVR compared to Hostaform® S 27064, with comparable mechanical properties, and is non-hygroscopic in nature. It is recommended for long flow length and/or thin-walled part geometries.

Physical properties	Value	Unit	Test Standard
Density	1370	kg/m ³	ISO 1183
Melt volume rate, MVR	39	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.65	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1600	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	38	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	12	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	8.5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 200	°C	-
Nozzle temperature	190 - 200	°C	-
Melt temperature	190 - 200	°C	-
Mold temperature	60 - 85	°C	-
Hot runner temperature	190 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	20	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow-medium	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	150	RPM	-
Screw speed diameter, 40mm	100	RPM	-
Screw speed diameter, 55mm	70	RPM	-

