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Celanese
The chemistry inside innovation™

HOSTAFORM® CKX-5766 - POM

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

Physical properties	Value	Unit	Test Standard
Density	**1390**	kg/m³	ISO 1183
Melt flow rate, MFR	**63**	g/10min	ISO 1133
MFR temperature	**190**	°C	ISO 1133
MFR load	**2.16**	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**2247**	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	**53**	MPa	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	**15**	%	ISO 527-2/1A
Flexural modulus, 23°C	**2100**	MPa	ISO 178
Flexural strength, 23°C	**53**	MPa	ISO 178
Charpy impact strength, 23°C	**114**[P]	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	**4.8**	kJ/m²	ISO 179/1eA

P: Partial Break

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	**83**	°C	ISO 75-1, -2

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 - 70**	°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	-

Characteristics

Product Categories	Delivery Form
Impact modified	Pellets
Processing	**Additives**
Injection molding	Release agent

Contact Information

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General Disclaimer

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