



HOSTAFORM® M25IE

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Hostaform® M25IE is a special grade of acetal copolymer targeted for calendering. It provides sheets with a high gloss and smooth surface.

Chemical abbreviation according to ISO 1043-1: POM

D	100		4.4
Prod	LICT I	ntarm	nation

Product information			
Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469
Rheological properties			
Melt volume-flow rate	2.5	cm ³ /10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Melt mass-flow rate	2.9	g/10min	ISO 1133
Melt mass-flow rate, Temperature	190	-	
Melt mass-flow rate, Load	2.16	kg	
Typical mechanical properties			
Tensile modulus	2400	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	61	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	11	%	ISO 527-1/-2
Flexural modulus	2400		ISO 178
Charpy impact strength, 23°C		kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C		kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C		kJ/m²	ISO 179/1eA
Poisson's ratio	0.38 ^[C]		
[P]: Partial Break			
[C]: Calculated			
Thermal properties			
Melting temperature, 10 ° C/min	163	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	91	°C	ISO 75-1/-2
Coefficient of linear thermal expansion	110	E-6/K	ISO 11359-1/-2
(CLTE), parallel			
Coefficient of linear thermal expansion (CLTE),	100	E-6/K	ISO 11359-1/-2
normal			
Physical/Other properties			
Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	1410	kg/m ³	ISO 1183
Injection			
Drying Recommended	no		
Drying Temperature	100	°C	
Drying Time, Dehumidified Dryer	3 - 4		
Processing Moisture Content	≤0.2	%	
Melt Temperature Optimum	200	°C	
NAIS would be seen a week was	100	0.0	

Printed: 2025-05-30 Page: 1 of 3

190 °C

210 °C

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Min. melt temperature Max. melt temperature





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Screw tangential speed≤0.3 m/sMold Temperature Optimum100 °CMin. mould temperature80 °CMax. mould temperature120 °CHold pressure range60 - 120 MPaBack pressure4 MPa

Characteristics

Processing Injection Moulding, Extrusion, Sheet Extrusion, Other Extrusion, Calendering

Delivery form Pellets

Additional information

Profile extrusion

Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Processing

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

Melt temperature 180-190 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C Annealing time 10 min/mm thickness

Sheet extrusion Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

Printed: 2025-05-30 Page: 2 of 3

Revised: 2024-07-08 Source: Celanese Materials Database





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Max. Water content 0,2 %

Processing

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Melt temperature 180-190 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C Annealing time 10 min/mm thickness

Processing Notes

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.

Printed: 2025-05-30 Page: 3 of 3

Revised: 2024-07-08 Source: Celanese Materials Database

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