

## HOSTAFORM® M30AE - POM

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

### Description

Hostaform® M30AE 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

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m <sup>3</sup>	ISO 1183
Melt volume rate, MVR	2.8	cm <sup>3</sup> /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Humidity absorption, 23°C/50%RH	0.2	%	ISO 62

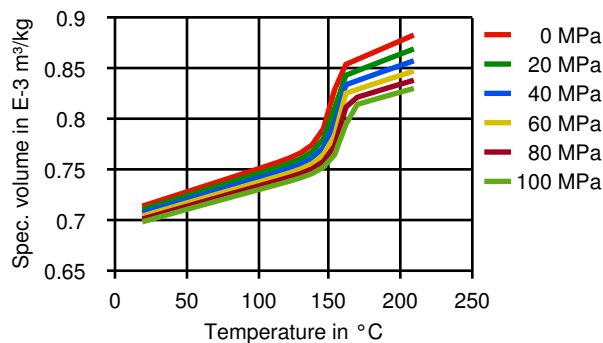
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2400	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	61	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	11	%	ISO 527-2/1A
Flexural modulus, 23°C	2400	MPa	ISO 178
Charpy impact strength, 23°C	250 <sup>[P]</sup>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	250	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5	kJ/m <sup>2</sup>	ISO 179/1eA

P: Partial Break

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	163	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	91	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	161	°C	ISO 306
Coeff. of linear therm expansion, parallel	1.1	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1	E-4/°C	ISO 11359-2

### Diagrams

#### Moldflow Specific volume-temperature (pvT)



#### Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
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	-

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Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°C	-
Nozzle temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°C	-
<b>Pressure</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Back pressure max.	40	bar	-
<b>Speed</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Injection speed	slow	-	-

### Other text information

#### 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.

#### 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

### Characteristics

#### Special Characteristics

High viscosity

#### Processing

Injection molding, Other extrusion, Sheet extrusion

#### Product Categories

Unfilled

#### Delivery Form

Pellets

### Contact Information

### General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use

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