

## HOSTAFORM® MT® SlideX® 2404 HOSTAFORM®

Hostaform® MT® SlideX® 2404 is a low melt viscosity injection molding grade for fast cycling and thin walled parts with tribological modification designed for use in demanding applications that require prevention of audible noise caused by stick-slip phenomenon and low friction and wear against plastics and metals.

Hostaform® MT® SlideX® 2404 is a special grade developed for medical industry applications and complies with:

- CFR 21 (177.2470) of the Food and Drug Administration (FDA) and is listed in the Drug Master File (DMF 11559) and the Device Master File (MAF 1079)
- the corresponding EU and national registry regulatory requirements
- biocompatibility in tests corresponding to USP <88> Class VI/ISO 10993
- low residual monomers
- no animal-derived constituents

### Product information

Resin Identification	POM	ISO 1043
Part Marking Code	>POM<	ISO 11469

### Rheological properties

Melt volume-flow rate	25 cm <sup>3</sup> /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage, parallel	1.9 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.8 %	ISO 294-4, 2577

### Typical mechanical properties

Tensile modulus	2550 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	55 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	7 %	ISO 527-1/-2
Nominal strain at break	50 %	ISO 527-1/-2
Flexural modulus	2300 MPa	ISO 178
Charpy impact strength, 23°C	160 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	150 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5 kJ/m <sup>2</sup>	ISO 179/1eA
Ball indentation hardness, H 358/30	130 MPa	ISO 2039-1
Poisson's ratio	0.38 <sup>[C]</sup>	

[C]: Calculated

### Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	90 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	140 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	140 E-6/K	ISO 11359-1/-2

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### Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.6 %	Sim. to ISO 62
Density	1400 kg/m <sup>3</sup>	ISO 1183

### Injection

Drying Recommended	no
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Processing Moisture Content	≤0.2 %
Melt Temperature Optimum	195 °C
Min. melt temperature	180 °C
Max. melt temperature	210 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	80 °C
Max. mould temperature	120 °C
Hold pressure range	60 - 120 MPa
Back pressure	4 MPa
Ejection temperature	133 °C

### Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Low wear / Low friction

### Additional information

Injection molding

#### Processing

See Processing Guide and Involve Celanese FTS support to obtain best quality parts

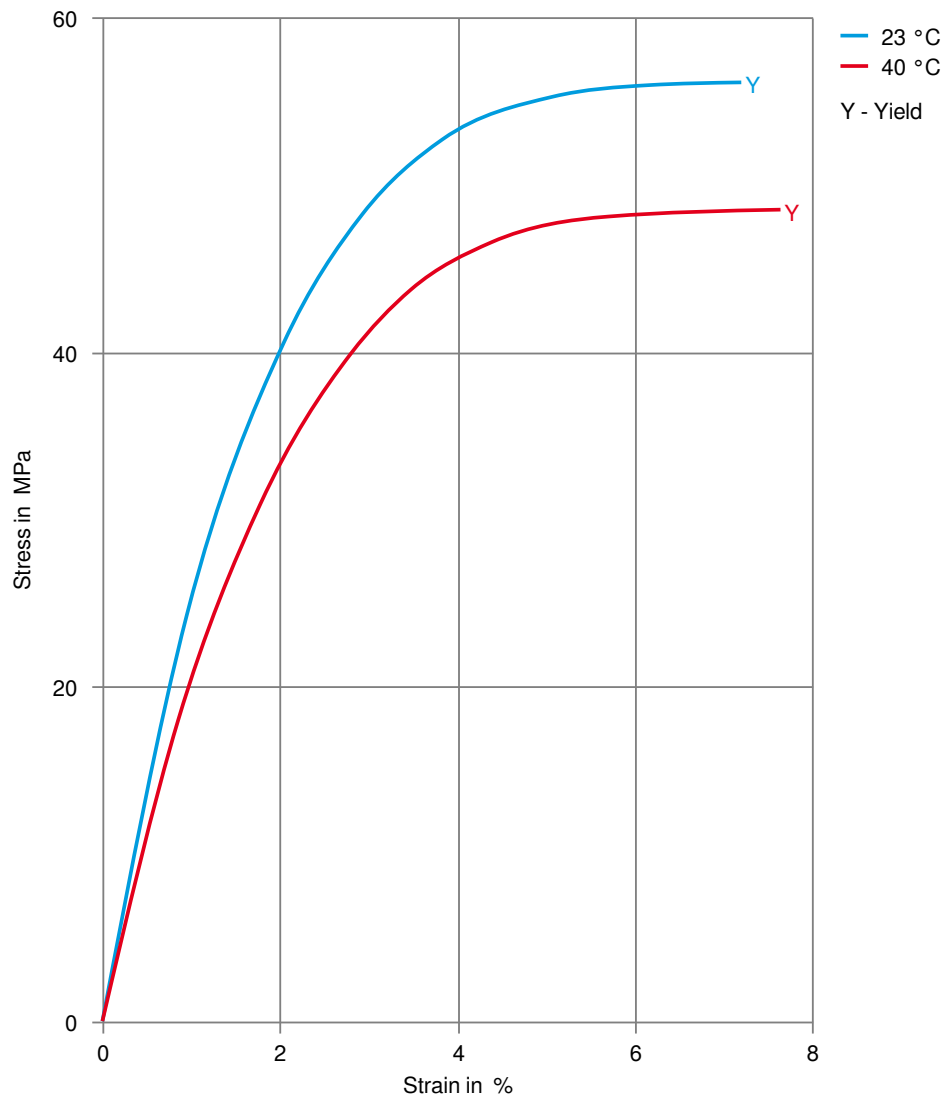
Processing Notes

#### Pre-Drying

recommended

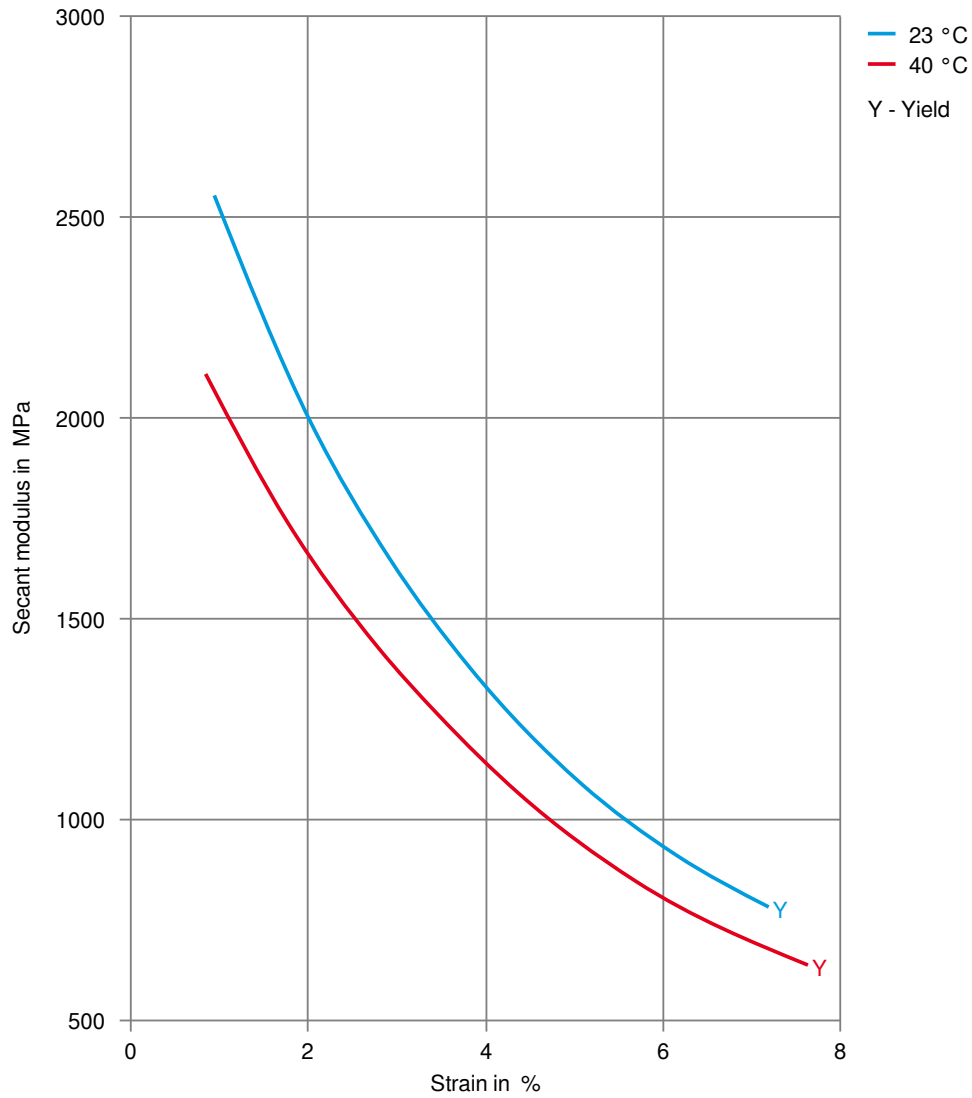
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Stress-strain



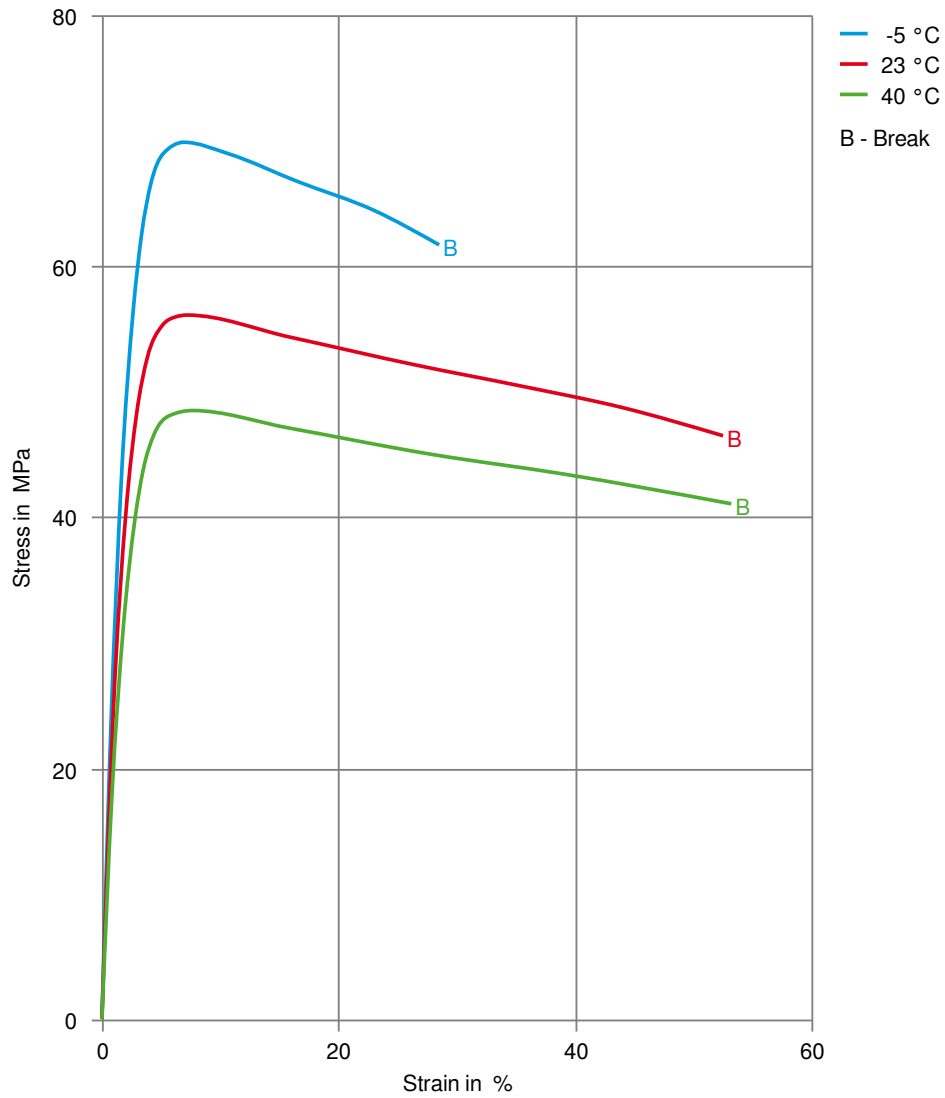
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Secant modulus-strain



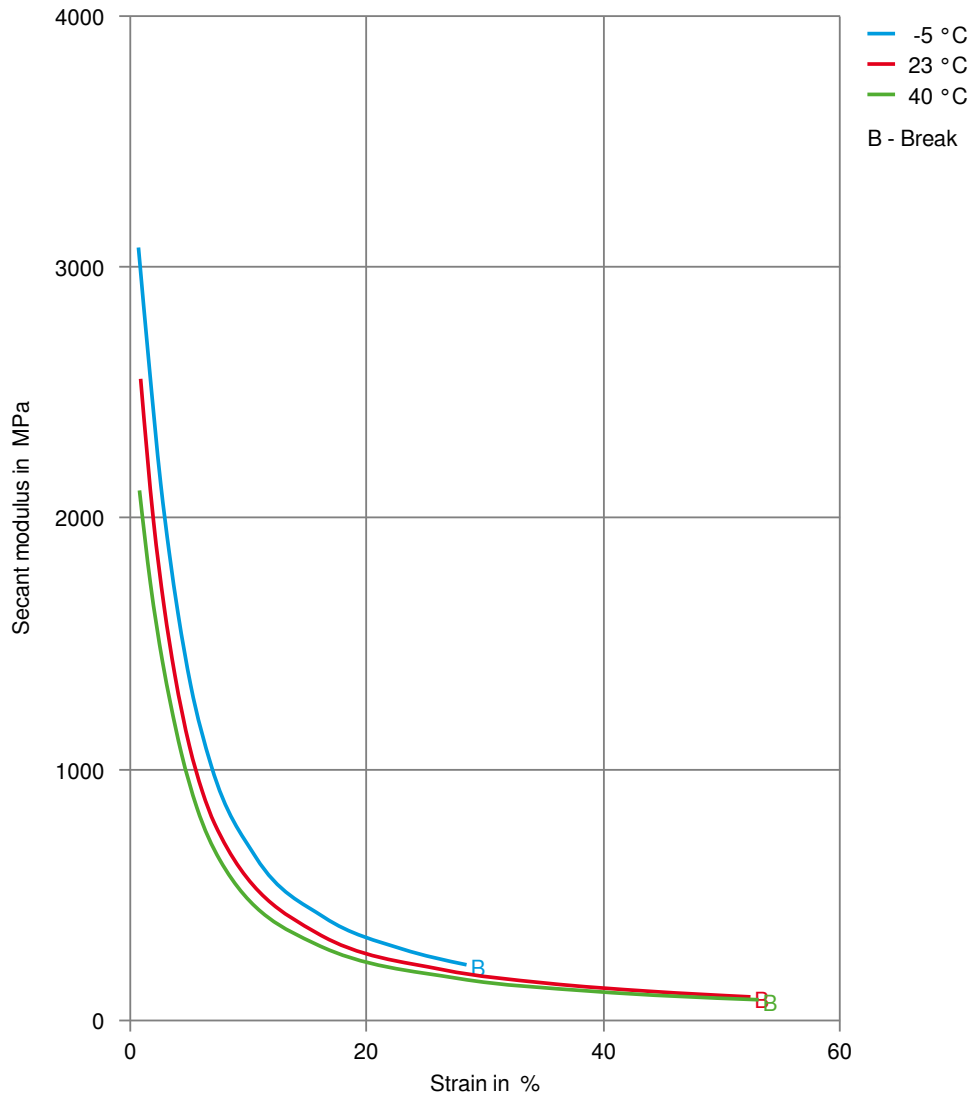
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Stress-strain, 50mm/min



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Secant modulus-strain, 50mm/min



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Page: 6 of 6

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