

High melt strength

POM copolymer

Stiff-flowing type with high melt strength; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.

Monomers and additives are listed in EU-Regulation (EU) 10/2011 FDA compliant according to 21 CFR 177.2470 Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm.

Ranges of applications: For extrusion blow molding, and for injection molding thick-walled, void-free molded parts.

Rheological properties

Melt volume-flow rate	0.9 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	

Typical mechanical properties

Tensile Modulus	2800	MPa	ISO 527-1/-2
Yield stress, 50mm/min	65	MPa	ISO 527-1/-2
Yield strain, 50mm/min	9	%	ISO 527-1/-2
Nominal strain at break	25	%	ISO 527-1/-2
Shear Modulus	889	MPa	ISO 6721
Tensile creep modulus, 1h	2400	MPa	ISO 899-1
Tensile creep modulus, 1000h	1200	MPa	ISO 899-1
Charpy impact strength, 23°C	220 ^[P]	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	200	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m²	ISO 179/1eA
[P]: Partial Break			

Thermal properties

Melting temperature, 10°C/min	167 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	97 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	150 °C	ISO 306
Coeff. of linear therm. expansion, parallel	130 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	4	IEC 62631-2-1
Dissipation factor, 100Hz	20 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	50 E-4	IEC 62631-2-1
Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	28 kV/mm	IEC 60243-1
Comparative tracking index	PLC 0 PLC	UL 746A

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Other properties

Injection

Drying Temperature 100 - 120 °C Drying Time, Dehumidified Dryer 3-4 h **Processing Moisture Content** 0.15 % Melt Temperature Optimum 200 °C Internal Screw tangential speed 0.2 - 0.21 m/s 80 - 120 °C Max. mould temperature Back pressure 4 MPa Injection speed slow-medium

Characteristics

Additives Release agent

Additional information

Film extrusion

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

Melt temperature 180-190 °C

Other extrusion

Standard extruders with grooved feed zone and short compression

screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Profile extrusion

Standard extruders with grooved feed zone and short compression

screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

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Sheet extrusion

Standard extruders with grooved feed zone and short compression

screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Blow molding

Standard extruders with plasticating screws (20 to 25 D) will fit.

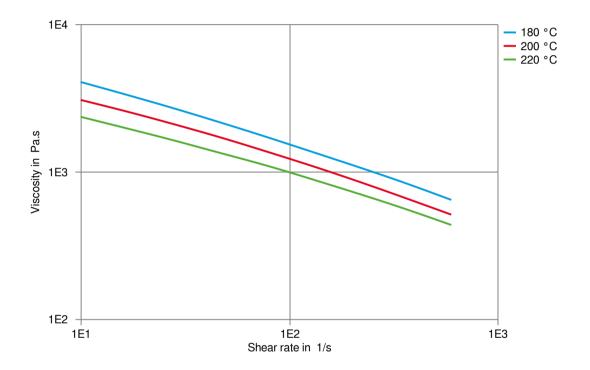
Melt temperature 180-190 °C

Mould-surface temperature 60-100 °C

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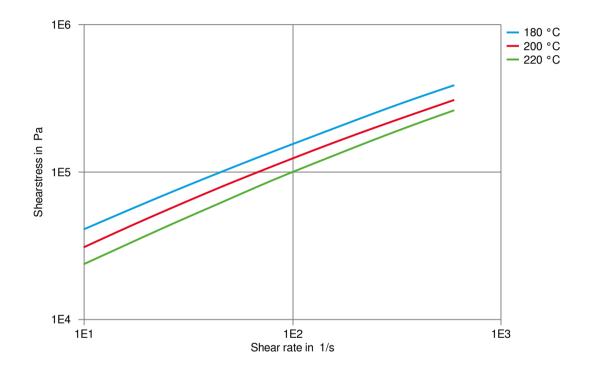
Viscosity-shear rate



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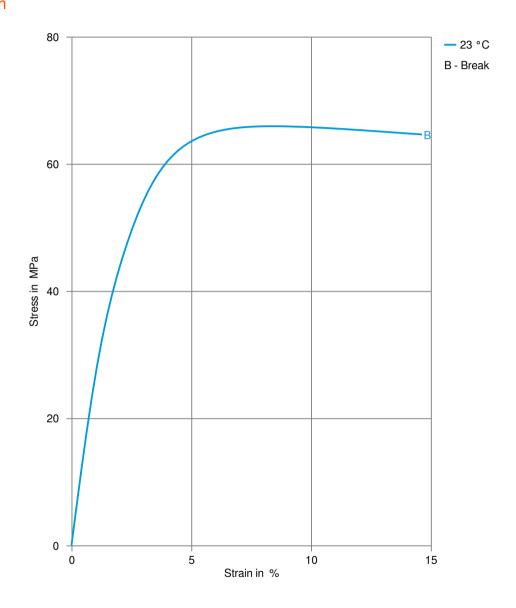
Shearstress-shear rate



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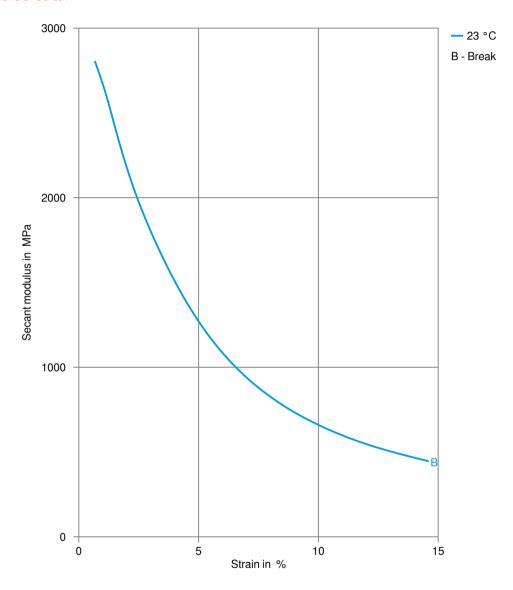
Stress-strain



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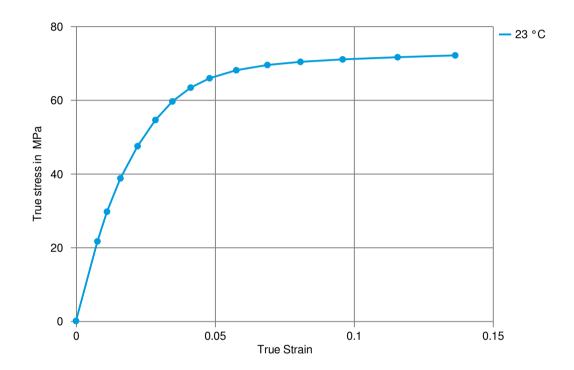
Secant modulus-strain



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True stress-strain



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Processing Texts

Pre-drying It is normally not necessary to dry HOSTAFORM. However, should there be

surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required. A circulating air drying cabinet can be used for this

purpose if the granul

Longer pre-drying times/storage The product can then be stored in standard conditions until processed.

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Revised: 2023-02-23 Source: Celanese Materials Database

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