

HOSTAFORM® M15HP

Low flow, high strength and stiffness, improved impact

Hostaform® acetal copolymer grade M15HP is a high viscosity polymer providing optimum performance in general purpose injection molding. This grade provides overall excellent performance in applications requiring high stiffness.

Rheological properties

Melt volume-flow rate	1.5 cm ³ /10min	ISO 1133
Melt mass-flow rate	1.8 g/10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Melt mass-flow rate, Temperature	190 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	2.6 %	ISO 294-4, 2577
Moulding shrinkage, normal	2.0 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2700 MPa	ISO 527-1/-2
Yield stress, 50mm/min	66 MPa	ISO 527-1/-2
Yield strain, 50mm/min	17 %	ISO 527-1/-2
Flexural Modulus	2500 MPa	ISO 178
Compressive stress at 1% strain	29 MPa	ISO 604
Charpy impact strength, 23°C	280 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	220 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	12 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8.5 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	9.5 kJ/m ²	ISO 180/1A
Hardness, Rockwell, M-scale	84	ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	173 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	101 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	158 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	166 °C	ISO 306
Vicat softening temperature, 50°C/h 10N	167 °C	ISO 306
Coeff. of linear therm. expansion, parallel	130 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.75 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183
Density of melt	1160 kg/m ³	Internal

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Injection

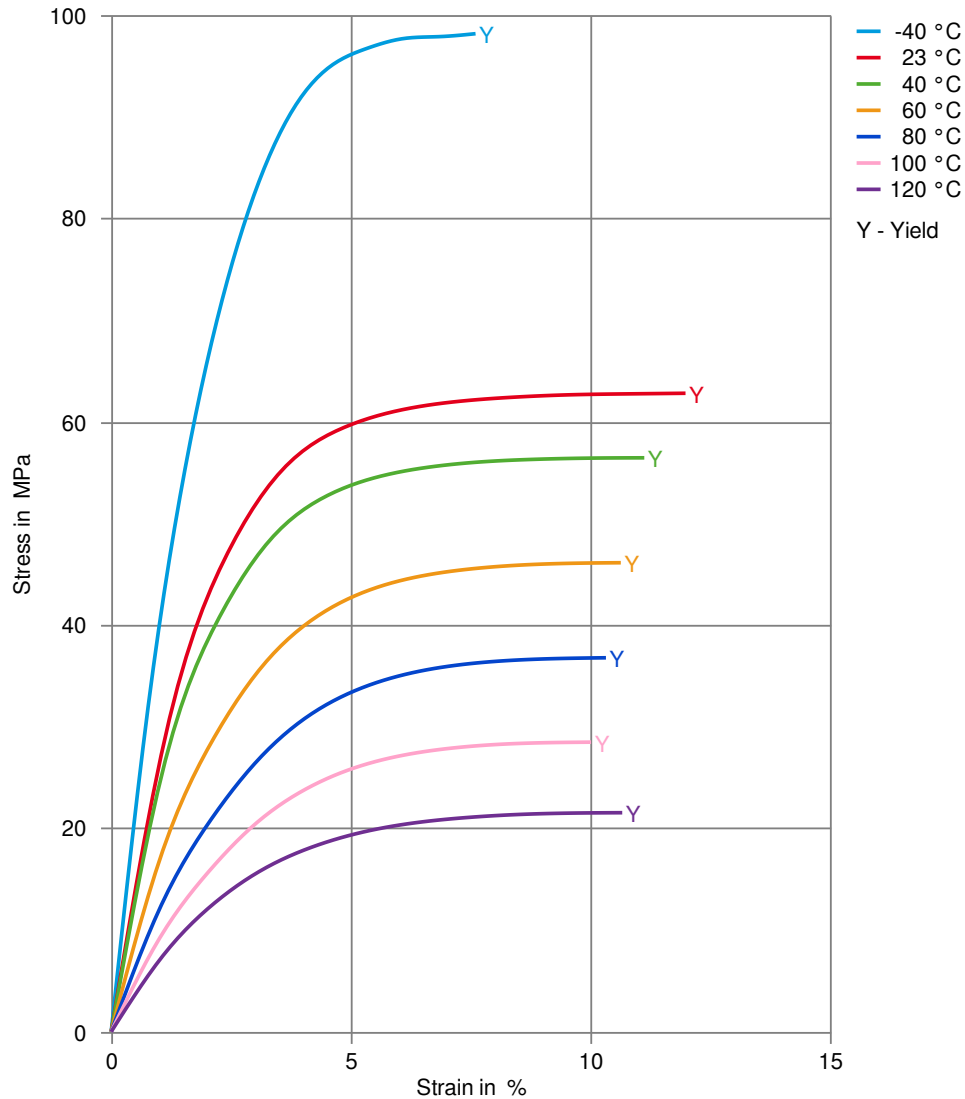
Drying Temperature	100 - 120 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Max. mould temperature	90 - 120 °C
Back pressure	4 MPa
Injection speed	slow

Characteristics

Additives	Release agent
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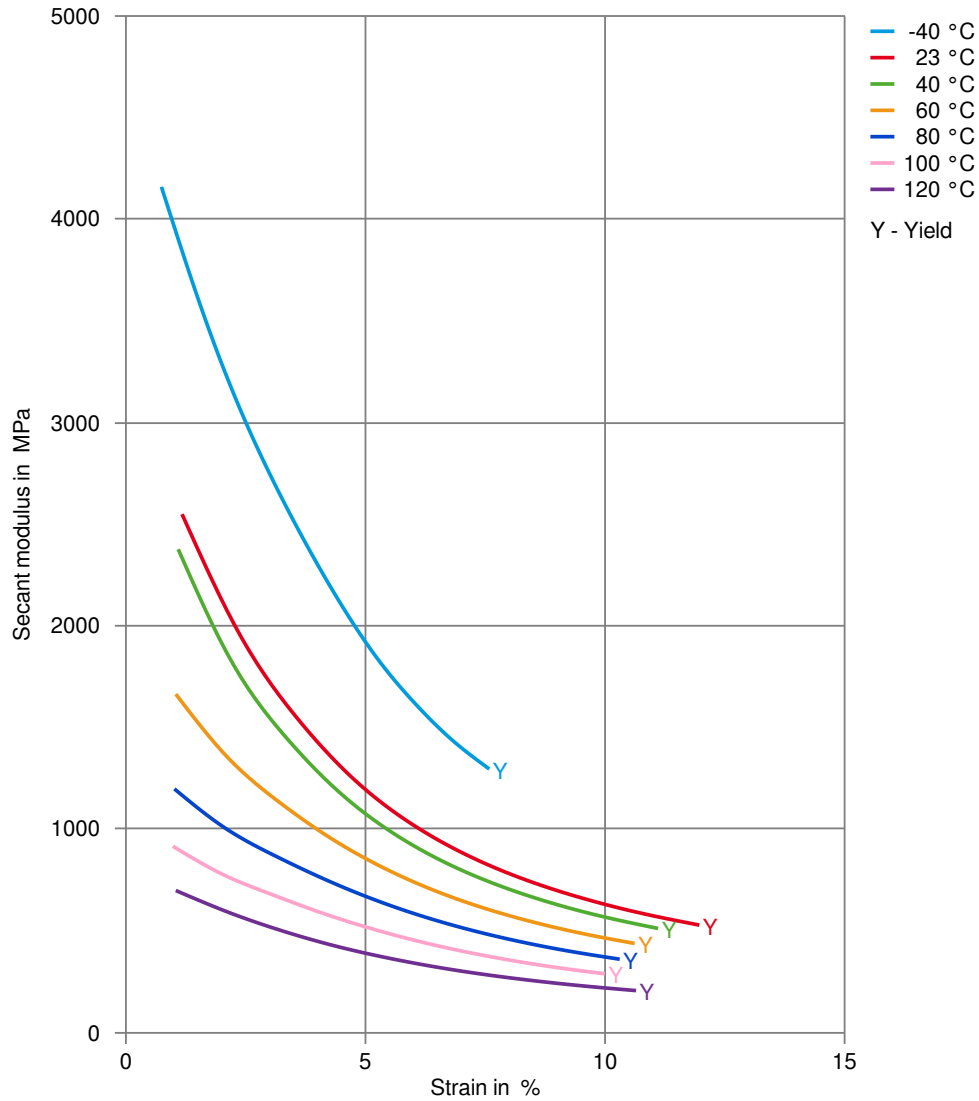
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Stress-strain



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Secant modulus-strain



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Processing Texts

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.

Other Approvals

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OEM	Specification	Additional Information
Continental	TST N 055 54.40	(TST N 055 54.40-001)
GM	GMW22P-POM-C1	