

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

	kg
Melt mass-flow rate, Load2.16Moulding shrinkage, parallel2.6Moulding shrinkage, normal2.0	% ISO 294-4, 2577
Typical mechanical properties	
Tensile Modulus2700Yield stress, 50mm/min66Yield strain, 50mm/min17Flexural Modulus2500Compressive stress at 1% strain29Charpy impact strength, 23°C280Charpy impact strength, -30°C220Charpy notched impact strength, 23°C12Charpy notched impact strength, -30°C8.5	MPa ISO 527-1/-2 MPa ISO 527-1/-2 % ISO 527-1/-2 MPa ISO 527-1/-2 MPa ISO 527-1/-2 MPa ISO 178 MPa ISO 178 MPa ISO 179/1eU kJ/m² ISO 179/1eU kJ/m² ISO 179/1eA kJ/m² ISO 179/1eA kJ/m² ISO 179/1eA ISO 180/1A ISO 2039-2
Thermal properties	
	°C ISO 75-1/-2 °C ISO 75-1/-2 °C ISO 306
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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

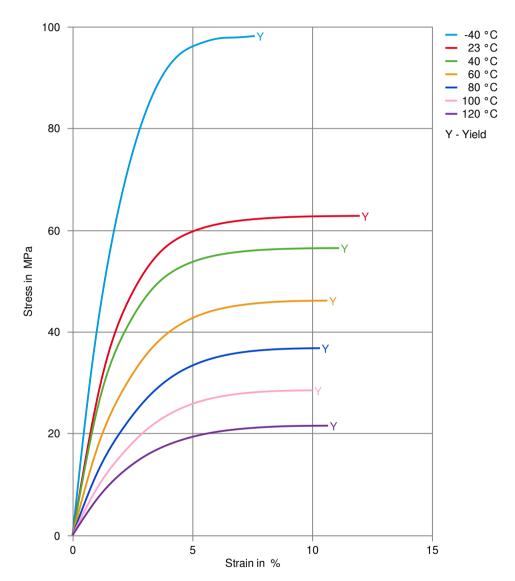
Characteristics

Additives

Release agent

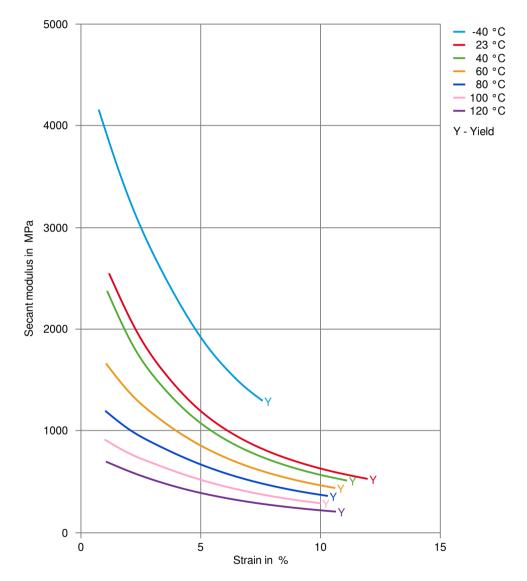


Stress-strain





Secant modulus-strain





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	

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