

HOSTAFORM[®] M25IE

special grade for calendering

Hostaform® M25IE is a special grade of acetal copolymer targeted for calendering. It provides sheets with a high gloss and smooth surface.

Chemical abbreviation according to ISO 1043-1: POM

Rheological properties

Melt volume-flow rate Melt mass-flow rate Temperature Load Melt mass-flow rate, Temperature Melt mass-flow rate, Load	2.5 2.9 190 2.16 190 2.16	cm ³ /10min g/10min °C kg °C kg	ISO 1133 ISO 1133
Typical mechanical properties			
Tensile Modulus Yield stress, 50mm/min Yield strain, 50mm/min Flexural Modulus Charpy impact strength, 23°C Charpy impact strength, -30°C Charpy notched impact strength, 23°C [P]: Partial Break	2400 61 11 2400 250 ^[P] 250 8.5	MPa MPa % MPa kJ/m ² kJ/m ²	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179/1eU ISO 179/1eU ISO 179/1eA
Thermal properties			
Melting temperature, 10 °C/min Temp. of deflection under load, 1.8 MPa Vicat softening temperature, 50 °C/h, 50N Coeff. of linear therm. expansion, parallel Coeff. of linear therm. expansion, normal	163 91 160 110 100	°C °C °C E-6/K E-6/K	ISO 11357-1/-3 ISO 75-1/-2 ISO 306 ISO 11359-1/-2 ISO 11359-1/-2
Other properties			
Humidity absorption, 2mm Density	0.2 1410	% kg/m³	Sim. to ISO 62 ISO 1183
Injection			
Drying Temperature Drying Time, Dehumidified Dryer Max. mould temperature Back pressure Injection speed	100 - 120 3 - 4 80 - 120 4 slow	°C h °C MPa	



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Additional information

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

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.

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