

Hostaform® MT® SlideX™ 2404

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade MT® SlideX™2404 is a special grade developed for medical industry applications containing low residual monomers and no animal products. 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.

General Information			
Features	Low friction coefficient		
	Low viscosity		
	Fast molding cycle		
	Good wear resistance		
	No kinetic components		
Uses	Thin wall parts		
	Medical/nursing supplies		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	25.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.60	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2550	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	55.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	50	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.5	kJ/m ²	ISO 179/1eA
23°C	5.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	150	kJ/m ²	ISO 179/1eU

23°C	160	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	90.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.4E-4	cm/cm/°C	ISO 11359-2
Lateral	1.4E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	170 - 175	°C	
Middle Temperature	180 - 185	°C	
Front Temperature	180 - 195	°C	
Nozzle Temperature	190 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 4.00	MPa	
Injection instructions			
Feed Temperature: 60 to 80°C Zone 4 Temperature: 180 to 200°C Manifold Temperature: 190 to 200°C			
NOTE			
1.	10°C/min		

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