

Hostaform® M25AE

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® M25AE is a special grade of acetal copolymer targeted for extrusion shapes (rod, bar, plate, etc) free of center porosity in large diameters and thicknesses.

Chemical abbreviation according to ISO 1043-1: POM

General Information			
UL YellowCard	E42337-234602		
Uses	Bar		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.50	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	61.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2400	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.5	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	91.0	°C	ISO 75-2/A
Melting Temperature ¹	163	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.0E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0	hr	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	190 - 200	°C	
Nozzle Temperature	190 - 210	°C	
Processing (Melt) Temp	190 - 210	°C	

Mold Temperature	80.0 - 120	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Manifold Temperature: 190 to 210°CZone 4 Temperature: 190 to 210°CFeed Temperature: 60 to 80°C

NOTE

1. 10°C/min

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