

HOSTAFORM® MR130ACS - POM

Description

Hostaform® acetal copolymer grade MR130ACS is a general purpose acetal with improved acid stabilization. Hostaform® MR130ACS demonstrates improved performance over standard acetals after intermittent exposure to acidic cleaners.

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate, MVR	12	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2,16	kg	ISO 1133
Water absorption, 23°C-sat	1,7	%	ISO 62
Humidity absorption, 23°C/50%RH	0,3	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2900	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	62	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	11	%	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	30	%	ISO 527-2/1A
Charpy impact strength, 23°C	150	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	140	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	6	kJ/m ²	ISO 179/1eA
Ball indentation hardness, 30s	137	MPa	ISO 2039-1

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	170	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	100	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	154	°C	ISO 306
Coeff. of linear therm expansion, parallel	0,94	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1	E-4/°C	ISO 11359-2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0,15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°C	-
Nozzle temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow-medium	-	-

Other text information

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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Longer pre-drying times/storage

Standard drying conditions are 82 deg C (180 deg F) for 3 hours.

Characteristics

Product Categories

Specialty

Delivery Form

Pellets

Processing

Injection molding

Additives

Release agent

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