HOSTAFORM® MR130HPB - POM

Description

Preliminary Data Sheet Hostaform® MR130HPB acetal copolymer is a high modulus, improved toughness grade based on our Hostaform® C 13031 product but specially formulated with improved resistance to intermittent bleach exposure.

Physical properties	Value	Unit	Test Standard
Density	**1410**	kg/m³	ISO 1183
Melt volume rate, MVR	**13**	cm³/10min	ISO 1133
MVR temperature	**190**	°C	ISO 1133
MVR load	**2,16**	kg	ISO 1133
Water absorption, 23°C-sat	**0,8**	%	ISO 62
Humidity absorption, 23°C/50%RH	**0,25**	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**3100**	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	**69**	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	**9**	%	ISO 527-2/1A
Flexural modulus, 23°C	**3000**	MPa	ISO 178
Flexural strength, 23°C	**80**	MPa	ISO 178
Charpy notched impact strength, 23°C	**6,5**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**6**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	**170**	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	**107**	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	**1,2**	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	**1,2**	E-4/°C	ISO 11359-2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
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	**180 - 200**	°C	-
Zone4 temperature	**180 - 210**	°C	-
Nozzle temperature	**180 - 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**	-	-

Other text information

Pre-drying

Drying not normally required. If material has contacted moisture through improper storage, handling, or regrind use, drying may be needed to prevent splay and odor.

Longer pre-drying times/storage

The product can then be stored in standard conditions until processed.

Characteristics

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Product Categories

Specialty

Delivery Form

Pellets

Processing

Injection molding

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