



Hostaform® M25AE

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

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

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Rods		
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Extrusion		
Resin ID (ISO 1043)	• POM		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.9	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.50	cm ³ /10min	ISO 1133
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	348000	psi	ISO 527-2/1A
Tensile Stress (Yield)	8850	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	348000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	4.0	ft·lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	120	ft·lb/in ²	
73°F, Partial Break	120	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	196	°F	ISO 75-2/A
Vicat Softening Temperature	320	°F	ISO 306/B50
Melting Temperature ²	325	°F	ISO 11357-3
CLTE - Flow	6.1E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	5.6E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F

Hostaform® M25AE

Celanese Corporation - Acetal (POM) Copolymer

Injection	Nominal Value	Unit
Nozzle Temperature	374 to 410	°F
Processing (Melt) Temp	374 to 410	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow	
Back Pressure	< 580	psi

Injection Notes

Feeding zone temperature: 60 to 80°C

Zone4 temperature: 190 to 210°C

Hot runner temperature: 190 to 210°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min