HOSTAFORM® MR130ACS

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

Product information

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469

Rheological properties

Melt volume-flow rate	12	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	

Typical mechanical properties

Tensile modulus	421000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	9000	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	11	%	ISO 527-1/-2
Nominal strain at break	30	%	ISO 527-1/-2
Charpy impact strength, 23°C	71.4	ftlb/in^2	ISO 179/1eU
Charpy impact strength, -30°C	66.6	ftlb/in^2	ISO 179/1eU
Charpy notched impact strength, 23°C	3.81	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -30°C	2.85	ftlb/in^2	ISO 179/1eA
Ball indentation hardness, H 358/30	19900	psi	ISO 2039-1

Thermal properties

Melting temperature, 10°C/min	338	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	212	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.52	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.556	E-4/°F	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.3	%	Sim. to ISO 62
Water absorption, 2mm	1.7	%	Sim. to ISO 62
Density	0.0509	lb/in^3	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	392	°F
Min. melt temperature	374	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°F
Max. mold temperature	248	°F

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Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	580	psi

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	Chemical resistant

Additional information

Processing Notes

Pre-Drying

Pre-drying is recommended.

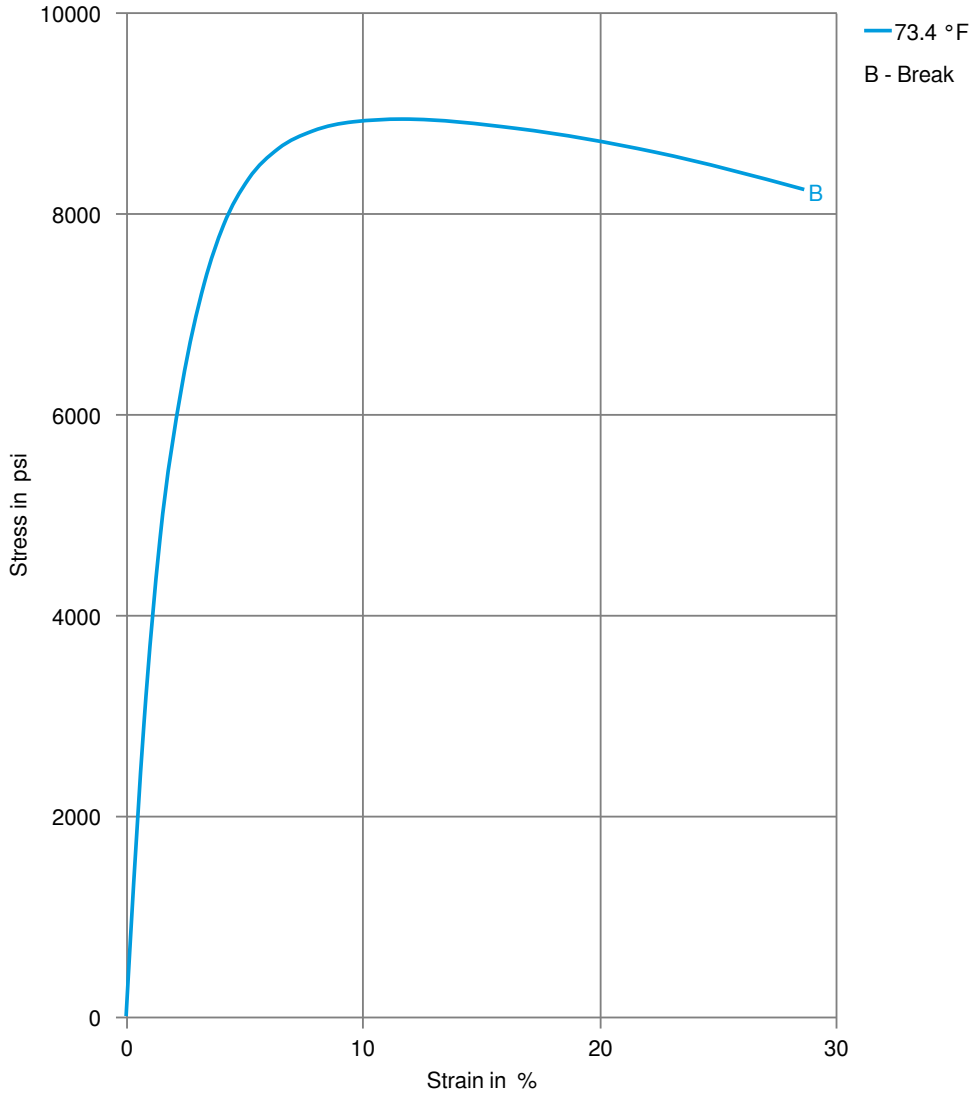
Storage

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

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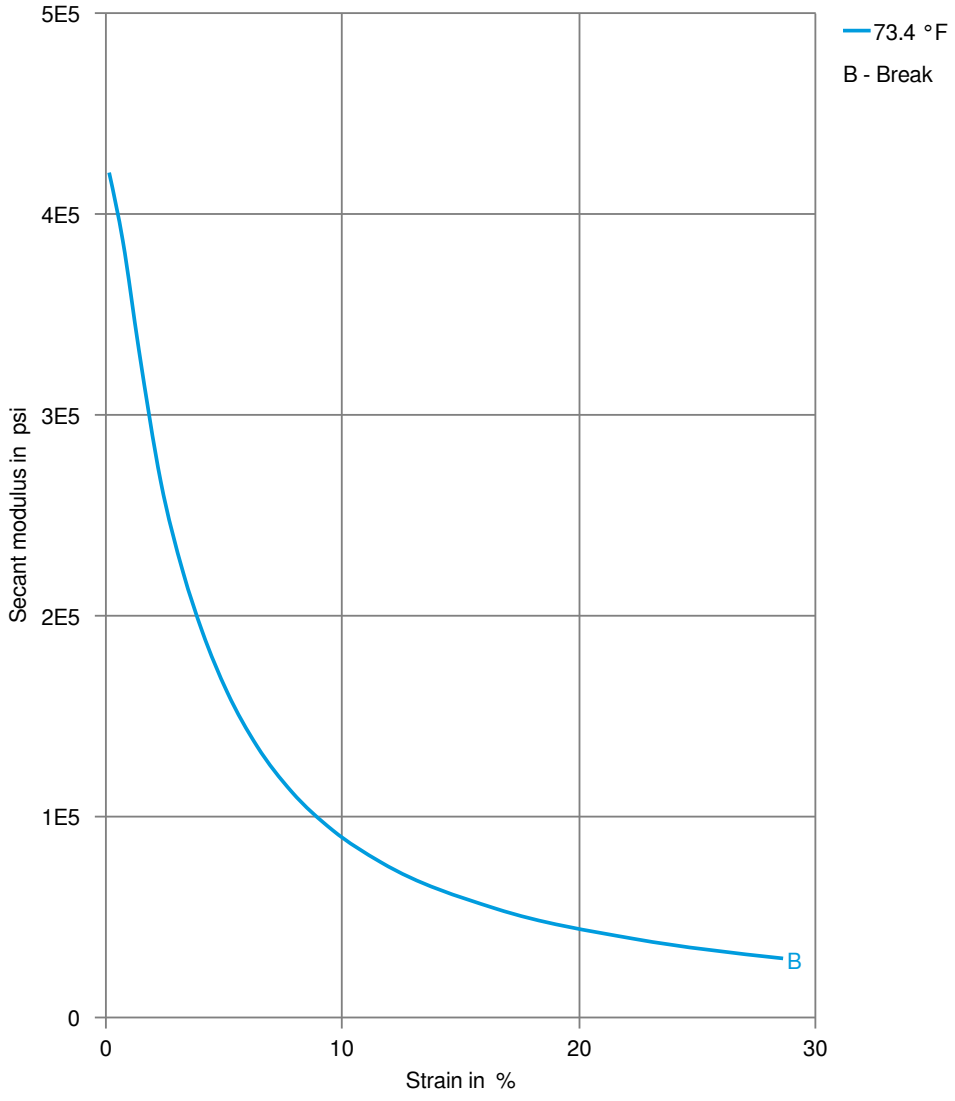
Stress-strain



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Secant modulus-strain



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