HOSTAFORM® MR130HPB

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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.

Product information

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

Rheological properties

Melt volume-flow rate	13	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	

Typical mechanical properties

Tensile modulus	450000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	10000	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	9	%	ISO 527-1/-2
Flexural modulus	435000	psi	ISO 178
Flexural strength	11600	psi	ISO 178
Charpy notched impact strength, 23°C	3.09	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -30°C	2.85	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	338	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	225	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.67	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.667	E-4/°F	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.25	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	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
Hold pressure range	8700 - 17400	psi

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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
Special characteristics	Chemical resistant

Additional information

Processing Notes

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.

Storage

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

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