Celanese
The chemistry inside innovation™

HOSTAFORM® RF2464

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Hostaform® POM RF2464 is an impact modified acetal copolymer that has been specially designed for Rotomolding. The material is UV stabilized and is available in natural or can be supplied in a pre-colored black. Hostaform® POM RF2464 has excellent toughness balanced with low fuel permeation and meets EPA and CARB regulations as a single layer solution in fuel tanks.

Product information

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

Rheological properties

Melt mass-flow rate	2.8	g/10min	ISO 1133
Melt mass-flow rate, Temperature	374	°F	
Melt mass-flow rate, Load	4.76	lb	
Molding shrinkage range, parallel	1.5 - 3	%	ISO 294-4, 2577
Molding shrinkage range, normal	1.5 - 3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	206000	psi	ISO 527-1/-2
Tensile modulus	210000	psi	ASTM D 638
Tensile stress at yield, 50mm/min	5800	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	40	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	4500	psi	ISO 527-1/-2
Tensile Strength	5800	psi	ASTM D 638
Tensile elongation at break	56.7	%	ASTM D 638
Tensile strain at break, 50mm/min	>50	%	ISO 527-1/-2
Flexural modulus	197000	psi	ISO 178
Flexural modulus	199000	psi	ASTM D 790
Shear Strength	5800	psi	ASTM D 732
Charpy impact strength, 23°C	N	ftlb/in^2	ISO 179/1eU
Charpy notched impact strength, 23°C	7.37	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -40°C	4.04	ftlb/in^2	ISO 179/1eA
Multiaxial impact, total energy, 23°C	310	in-lb	ASTM D 3763
Multiaxial impact, maximum load, 23°C	4000	N	ASTM D 3763
Mean Failure Energy, 23°C	17	ft-lb	ARM Impact Test
Mean Failure Energy, -20°C	9.96	ft-lb	ARM Impact Test
Mean Failure Energy, -40°C	6.64	ft-lb	ARM Impact Test

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 0.45MPa	257	°F	ASTM D 648
Temperature of deflection under load, 1.8MPa	153	°F	ASTM D 648

Physical/Other properties

Density	0.048	lb/in^3	ISO 1183

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Characteristics

Processing	Rotational Molding
Special characteristics	High impact or impact modified, Light stabilized or stable to light

Additional information

Rotomolding

Preprocessing

Typical Oven Times (440-520ºF (225ºC-270ºC) typical set temps. on gas ovens and aluminum tooling)
*Oven types, times and temperatures can vary.
*Outer wall material temperature should not exceed 450ºF/232ºC.
0.150” wall (3.8 mm) 15-20 minutes
0.200” wall (5.1mm) 18-35 minutes
Typical Air Cooling
Rotate in air 0*-20 minutes (5-10 min. recommended)
*Although some tooling configurations could allow 0min in air possible, it is not recommended to perform a quick cool down right out of the oven.
Rotate in forced air 10-30 minutes. Water cooling of tool may be used.
Ideal IAT (Internal Air Temperature)
375ºF (190ºC) 4-12 minutes (365ºF - 400ºF typical)
405ºF (207ºC) do not exceed
< 150ºF (93ºC) recommended demold temp.
Outer wall Temp.
410-450ºF (210-232ºC) Typical
450ºF (232ºC) do not exceed

Processing

Existing molds usually suitable (Typical mold shrink is 1.5-3%)
Standard Pulverizers (attrition mills) are suitable. Product available in powder. Pellets should be reduced to 35mesh.
ARM 2.1 Flowability and Bulk Density Funnels are suitable to test powder.
Mold Releases can cause surface blistering. Mold Release or special tool coatings typically not needed. Compatible with certain flow enhancing products. Consult a Celanese representative for recommendations.

Start with a clean, blasted and grained tooling surface. For parting lines, removing all remnants of previous materials used in the tooling. Allow 1 or 2 molding shots to remove blasting residue.
Typical 4:1 ratio Major/Minor axis rotational speed (8:2, 6:1.5, etc.)
Product exhibits good flow and seal around in-mold inserts.
Compatible with most secondary operations (In mold & post mold labelling,

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machining, assembly, etc). Flame treating not recommended.

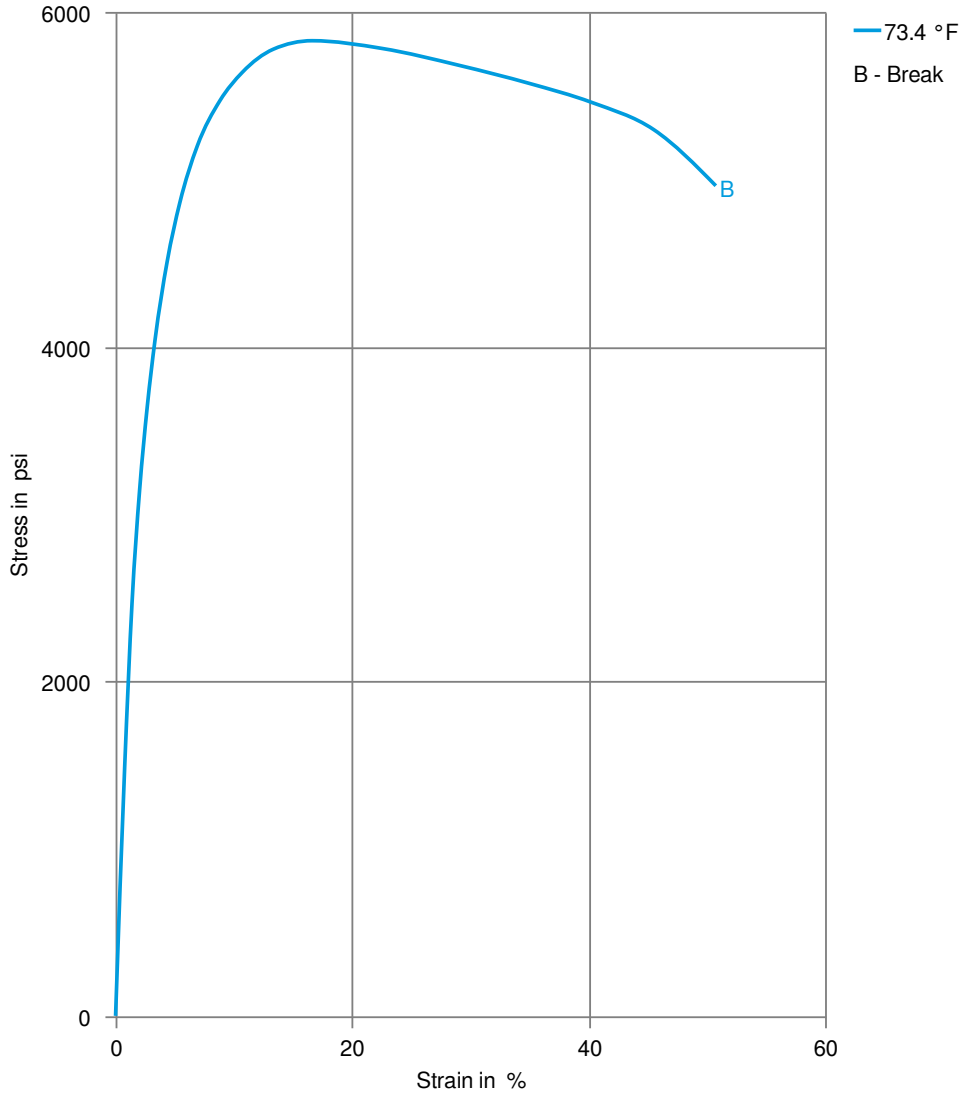
Ensure adequate ventilation at all stages of the process including demolding.

Following demold allow part to cool to room temperature and inside of part to fully vent and evacuate air and gasses before performing secondary processing or examinations.

Avoid inadvertant mixing with PVC even in trace amounts.

Do not perform oven or tool burn-outs to clean polymer from ovens or tools.

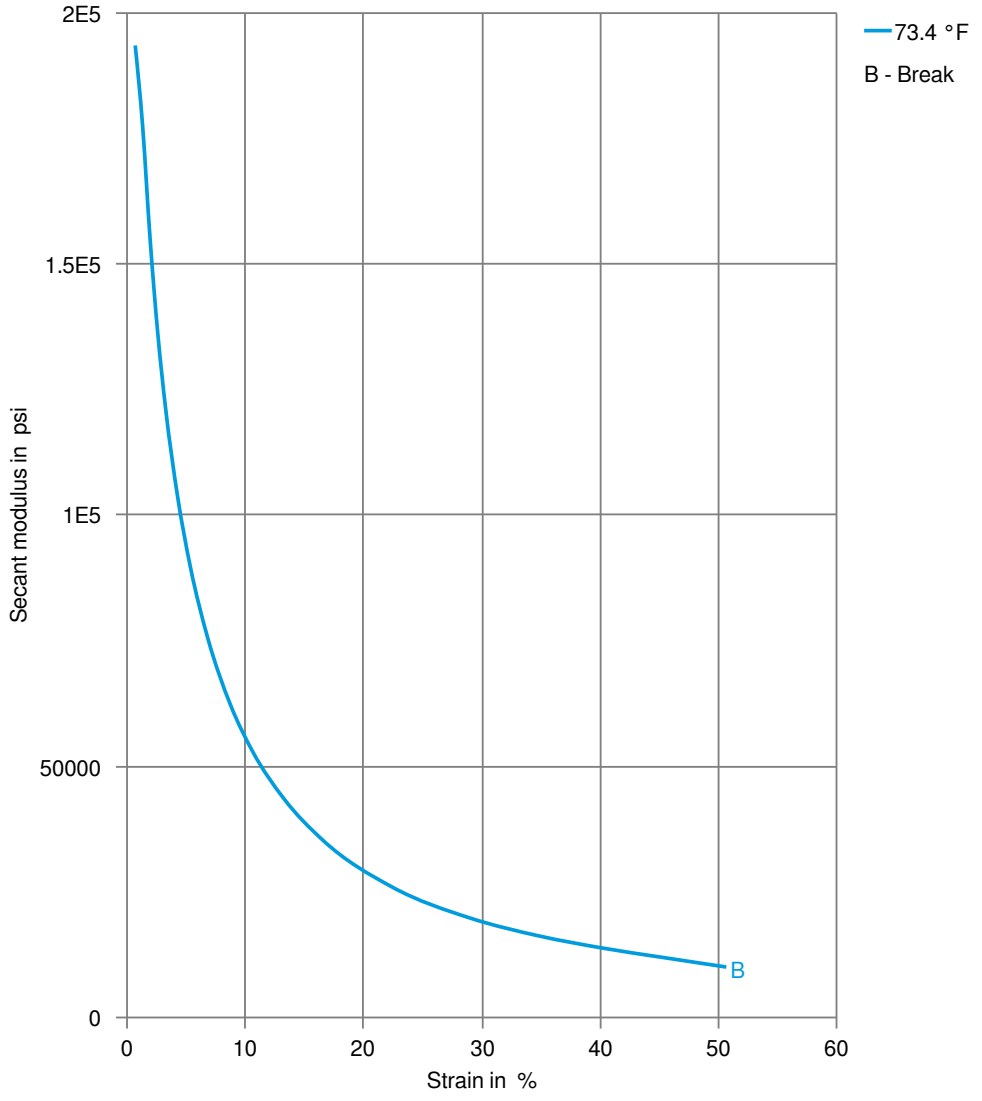
Stress-strain



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Secant modulus-strain



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