HOSTAFORM® RF2464WR BLK2

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Product information

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

Rheological properties

Melt mass-flow rate	3.5	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	232000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	5800	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	20	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	4640	psi	ISO 527-1/-2
Tensile strain at break, 50mm/min	>50	%	ISO 527-1/-2
Flexural modulus	210000	psi	ISO 178
Flexural stress at 3.5%	5370	psi	ISO 178
Charpy notched impact strength, 23°C	5.71	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -40°C	3.33	ftlb/in^2	ISO 179/1eA
Multiaxial impact, total energy, 23°C	274	in-lb	ASTM D 3763
Multiaxial impact, maximum load, 23°C	3900	N	ASTM D 3763
Mean Failure Energy, 23°C	17	ft-lb	ARM Impact Test
Mean Failure Energy, -40°C	5.16	ft-lb	ARM Impact Test

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	153	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	266	°F	ISO 75-1/-2

Physical/Other properties

Density	0.048	lb/in^3	ISO 1183

Characteristics

Processing	Rotational Molding
Special characteristics	High impact or impact modified

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, 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.

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