

HOSTAFORM® S 9364 - POM

Description

Hostaform® acetal copolymer grade S 9364 is highly impact modified grade for demanding applications. Hostaform® S 9364 provides a significant improvement in impact strength and flexibility over standard impact modified grades such as Hostaform® S 9063 and S 9064. Chemical abbreviation according to ISO 1043-1: POM-HI

Physical properties	Value	Unit	Test Standard
Density	1370	kg/m ³	ISO 1183
Melt volume rate, MVR	4	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Molding shrinkage, parallel	1.6	%	ISO 294-4, 2577
Molding shrinkage, normal	1.5	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.8	%	ISO 62
Humidity absorption, 23°C/50%RH	0.25	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1650	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	43	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	16	%	ISO 527-2/1A
Flexural modulus, 23°C	1550	MPa	ISO 178
Flexural stress at 3.5% strain	42	MPa	ISO 178
Charpy impact strength, 23°C	NB	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	NB	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	21	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	11	kJ/m ²	ISO 179/1eA
Izod impact notched, 23°C	20	kJ/m ²	ISO 180/1A
Izod impact notched, -30°C	12	kJ/m ²	ISO 180/1A
Izod impact notched, -40°C	10	kJ/m ²	ISO 180/1A
Izod impact unnotched, 23°C	NB	kJ/m ²	ISO 180/1U
Izod impact unnotched, -30°C	NB	kJ/m ²	ISO 180/1U
Shore D hardness, 15s	76	-	ISO 868

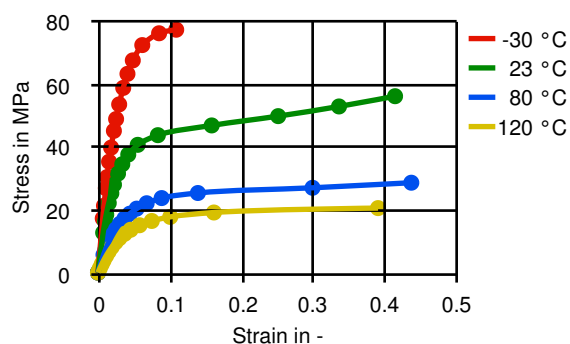
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	75	°C	ISO 75-1, -2
DTUL at 0.45 MPa	140	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	122	°C	ISO 306
Coeff. of linear therm expansion, parallel	1.2	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1.1	E-4/°C	ISO 11359-2

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988-2	-	Internal
Injection Molding, melt temperature	205	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294
Injection Molding, pressure at hold	86	MPa	ISO 294

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Diagrams

True Stress-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	180 - 190	°C	-
Zone4 temperature	180 - 200	°C	-
Die temperature	180 - 200	°C	-
Melt temperature	180 - 200	°C	-
Cavity temperature	60 - 70	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	20	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow	-	-

Other text information

Pre-drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying to prevent splay and odor problems.

Characteristics

Product Categories	Delivery Form
Impact modified	Pellets
Processing	Additives
Injection molding	Release agent

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General Disclaimer

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