

Hostaform® MT12U03

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® MT12U03 is a special grade developed for medical industry applications containing low residual monomers and no animal products. Hostaform® MT12U03 is a moderately high flow grade for faster cycling and thin walled injection molding with improved stiffness and hardness compared to Hostaform® MT12U01.

General Information			
Features	Rigidity, high		
	Fast molding cycle		
	Good liquidity		
	High liquidity		
	No kinetic components		
Uses	Thin wall parts		
	Medical/nursing supplies		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12.0	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	2.0	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	70.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	20	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	2750	MPa	ISO 899-1
1000 hr	1450	MPa	ISO 899-1
Flexural Modulus (23°C)	3000	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m²	ISO 179/1eA
23°C	6.0	kJ/m²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	120	kJ/m ²	ISO 179/1eU
23°C	120	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	112	°C	ISO 75-2/A
Melting Temperature ¹	170	°C	ISO 11357-3
CLTE - Flow	1.2E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	190 - 200	°C	
Nozzle Temperature	190 - 210	°C	
Processing (Melt) Temp	190 - 210	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 0.500	MPa	
Injection instructions			
Manifold Temperature: 190 to 210°CZone 4 Temperature: 190 to 210°C			
NOTE			
1.	10°C/min		

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