

HOSTAFORM® LM25 - POM

Description

Hostaform® LM25 is a 2.5 melt flow acetal copolymer which is capable of being permanently marked by a laser. Parts molded from Hostaform® LM25 can be lasermarked with bar-codes, identification numbers, designs, 2-D symbology, etc.

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate, MVR	2,2	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2,16	kg	ISO 1133
Water absorption, 23°C-sat	0,75	%	ISO 62
Humidity absorption, 23°C/50%RH	0,2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2500	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	64	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	12	%	ISO 527-2/1A
Flexural modulus, 23°C	2500	MPa	ISO 178
Charpy notched impact strength, 23°C	5,7	kJ/m ²	ISO 179/1eA
Izod impact notched, 23°C	5,7	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	167	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	98	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	161	°C	ISO 306
Coeff. of linear therm expansion, parallel	1,1	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1,1	E-4/°C	ISO 11359-2

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	190 - 200	°C	-
Nozzle temperature	190 - 200	°C	-
Melt temperature	180 - 200	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	180 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	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 may be necessary to prevent splay and odor problems.

Characteristics

Special Characteristics

Laser markable

Processing

Injection molding

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Product Categories

Specialty

Delivery Form

Pellets

Contact Information

Americas

8040 Dixie Highway
Florence, KY 41042 USA
Product Information Service
t: +1-800-833-4882
t: +1-859-372-3244
Customer Service
t: +1-800-526-4960
t: +1-859-372-3214
e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road
Zhang Jiang Hi Tech Park
Shanghai 201203 PRC
Customer Service
t: +86 21 3861 9266
f: +86 21 3861 9599
e: info-engineeredmaterials-
asia@celanese.com

Europe

Am Unisys-Park 1
65843 Sulzbach, Germany
Product Information Service
t: +49-800-86427-531
t: +49-(0)-69-45009-1011
e: info-engineeredmaterials-eu@celanese.com

General Disclaimer

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