

HOSTAFORM® LX90GC15 - POM

Description

Preliminary Data Sheet Hostaform® LX90GC15 is a specialty metallic appearance acetal copolymer grade that is integrally colored and has a nominal 15% fiber glass loading. This grade provides additional strength and stiffness over unfilled acetal grades while presenting a metal appearance surface. Besides material, optimal finish for specialty metallic parts is dependent on proper drying, gate design, knit line locations, and special processing. Please contact Celanese Technical Service for assistance with your application. Chemical abbreviation according to ISO 1043-1: POM

Physical properties	Value	Unit	Test Standard
Density	1500	kg/m ³	ISO 1183
Molding shrinkage, parallel	0,7	%	ISO 294-4, 2577
Molding shrinkage, normal	1,2	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0,85	%	ISO 62
Humidity absorption, 23°C/50%RH	0,2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	5500	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	75	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	4	%	ISO 527-2/1A
Flexural modulus, 23°C	5200	MPa	ISO 178
Charpy notched impact strength, 23°C	4	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	155	°C	ISO 75-1, -2
DTUL at 0.45 MPa	161	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	0,5	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1	E-4/°C	ISO 11359-2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0,15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°C	-
Nozzle temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°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 required for this material to prevent poor appearance and performance of the part.

Longer pre-drying times/storage

The product can then be stored in standard conditions until processed.

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Characteristics

Product Categories

Specialty

Delivery Form

Pellets

Processing

Injection molding

Additives

Release agent

Contact Information

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General Disclaimer

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