

Hostaform® LM25

Acetal (POM) Copolymer

Celanese Corporation

Message:

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.

General Information			
Features	Laser marking		
	Good toughness		
RoHS Compliance		Contact manufacturer	
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.20	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.75	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	64.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.7	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	98.0	°C	ISO 75-2/A
Melting Temperature ¹	167	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.1E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	190 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	

Injection Rate	Slow	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa
Injection instructions		
Manifold Temperature: 180 to 200°CZone 4 Temperature: 190 to 200°C		
NOTE		
1.	10°C/min	

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