Hostaform® LX90Z

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® LX90Z specialty metallic appearance grades are an integrally colored nominal 9 melt flow rate based acetal copolymer material stabilized for use where ultraviolet radiation exposure is to be encountered. The material is formulated to prevent discoloration, fading, chalking and mechanical property change in severe ultraviolet exposure.
This product, formerly called Celcon® UV90Z metallics, is available in many molded-in-color metallic colors formulated for the interior automotive market and other applications.
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.

General Information	
UL YellowCard	E38860-101788886
Features	Good UV resistance
Uses	Application in Automobile Field Car interior parts
RoHS Compliance	Contact manufacturer
Appearance	Metallization-dyeing Available colors

Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.4	%	ISO 294-4
Flow direction	2.3	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.75	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	54.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2850	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.0	kJ/m²	ISO 179/1eA
23°C	4.0	kJ/m²	ISO 179/1eA
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	151	°C	ISO 75-2/B

1.8 MPa, not annealed	88.0	°C	ISO 75-2/A
Melting Temperature [1]	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	9.0E-5	cm/cm/°C	ISO 11359-2
Lateral	1.0E-4	cm/cm/°C	ISO 11359-2

Injection	Nominal Value	Unit
Drying Temperature	105 - 110	°C
Drying Time	3.0	hr
Rear Temperature	170 - 175	°C
Middle Temperature	170 - 180	°C
Front Temperature	175 - 185	°C
Nozzle Temperature	185 - 195	°C
Processing (Melt) Temp	180 - 195	°C
Mold Temperature	100 - 125	°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: 180 to 190°C

NOTE	
1.	10°C/min

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