Hostaform® LX90GC15

Acetal (POM) Copolymer

Celanese Corporation

Message:

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

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Rigid, good Good strength		
RoHS Compliance	Contact manufacturer		
Appearance	Metallization-dyeing		
Resin ID (ISO 1043)	POM		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.50	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.2	%	ISO 294-4
Flow direction	0.70	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.85	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	5500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	75.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	5200	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	161	°C	ISO 75-2/B
1.8 MPa, not annealed	155	°C	ISO 75-2/A
Melting Temperature [1]	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	5.0E-5	cm/cm/°C	ISO 11359-2
Lateral	1.0E-4	cm/cm/°C	ISO 11359-2

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 120	°C
Drying Time	3.0 - 4.0	hr
Hopper Temperature	20.0 - 30.0	°C
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	
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°CFeed Temperature: 60 to 80°C

NOTE	
1.	10°C/min

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

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