



Hostaform® LX90

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Preliminary Data Sheet Hostaform® LX90 specialty metallic appearance grades are an integrally colored nominal 9 melt flow rate based acetal copolymer material formulated to provide an exceptional molded in metallic appearance. This product is available in many metallic molded-in- colors. 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

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Surface Finish		
RoHS Compliance	• Contact Manufacturer		
Appearance	• Metallized - Colors		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 73°F)	0.75	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	392000	psi	ISO 527-2/1A
Tensile Stress (Yield)	8120	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	392000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	1.9	ft·lb/in ²	
73°F	2.4	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	190	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3
Melting Temperature	329	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	338 to 347	°F
Middle Temperature	338 to 356	°F
Front Temperature	347 to 365	°F
Nozzle Temperature	365 to 383	°F
Processing (Melt) Temp	356 to 383	°F
Mold Temperature	176 to 221	°F
Injection Rate	Slow	

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Injection	Nominal Value	Unit
Back Pressure	< 580	psi

Injection Notes

Zone4 temperature: 180 to 190°C
Hot runner temperature: 180 to 200°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min