



Hostaform® LX90GC15

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product 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

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• Good Stiffness	• Good Strength	• Good Surface Finish
RoHS Compliance	• Contact Manufacturer		
Appearance	• Metallized - Colors		
Resin ID (ISO 1043)	• POM		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.2	%	
Flow	0.70	%	
Water Absorption (Saturation, 73°F)	0.85	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	798000	psi	ISO 527-2/1A
Tensile Stress (Break)	10900	psi	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	754000	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	1.9	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	322	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	311	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3
CLTE - Flow	2.8E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	5.6E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr

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Injection	Nominal Value	Unit
Suggested Max Moisture	0.15	%
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 410	°F
Processing (Melt) Temp	374 to 410	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 190 to 210°C
Hot runner temperature: 190 to 210°C

Notes

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

² 10°C/min