



Hostaform® M90XAP®

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Hostaform® acetal copolymer grade M90 XAP® is a low emission version, medium viscosity polymer providing optimum performance in general purpose injection molding primarily for the interior automotive market. This grade provides overall excellent performance in many applications.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose	• Low Emissions	• Medium Viscosity
Uses	• Automotive Applications	• Automotive Interior Parts	• General Purpose
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.8	%	
Flow	1.8	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	377000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9430	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	9.5	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	371000	psi	ISO 178
Flexural Stress (3.5% Strain)	10600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.0	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact Strength (73°F)	2.6	ft-lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	212	°F	ISO 75-2/A
Vicat Softening Temperature	320	°F	ISO 306/B50
Melting Temperature ²	333	°F	ISO 11357-3
CLTE - Flow	6.7E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.7E-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
Rear Temperature	329 to 347	°F
Middle Temperature	338 to 356	°F
Front Temperature	338 to 356	°F
Nozzle Temperature	356 to 374	°F

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Injection	Nominal Value	Unit
Processing (Melt) Temp	356 to 374	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 580	psi

Injection Notes

Zone4 temperature: 175 to 185°C
Hot runner temperature: 180 to 200°C

Notes

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

² 10°C/min