

HOSTAFORM® LX90 | POM | Unfilled

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 Ticona Technical Service for assistance with your application.

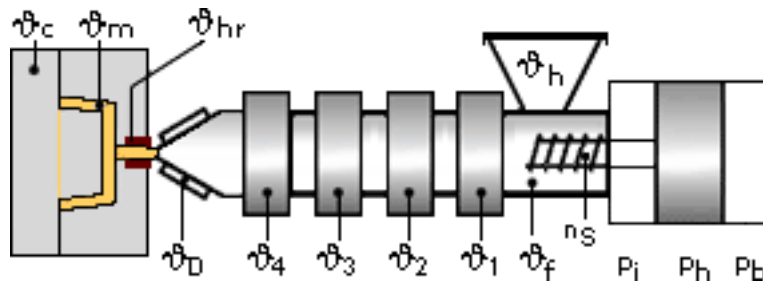
Physical properties	Value	Unit	Test Standard
Density	1430	kg/m ³	ISO 1183
Melt volume rate (MVR)	8	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Water absorption (23°C-sat)	0.75	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2700	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	56	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	10	%	ISO 527-2/1A
Flexural modulus (23°C)	2700	MPa	ISO 178
Charpy notched impact strength @ 23°C	5.0	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	4.0	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	166	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	88	°C	ISO 75-1/-2

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988-2	-	Internal

Typical injection moulding processing conditions



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Pre Drying:

Drying is required for this material to prevent poor appearance and performance of the part.

Drying time: 3 h

Drying temperature: 105 - 110 °C

Temperature:

	°Manifold	°Mold	°Melt	°Nozzle	°Zone4	°Zone3	°Zone2	°Zone1
min (°C)	180	80	180	185	180	175	170	170
max (°C)	200	105	195	195	190	185	180	175

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	5

Speed:

Injection speed: slow

Special Info:

Gate and knit line locations are important in order to minimize surface defects and blemishes. Processing parameters can be optimized for surface performance. Please contact Ticona Technical Service to assist with your application.

Contact Information

Americas

8040 Dixie Highway, Florence, KY 41042 USA

Product Information Service

t: +1-800-833-4882 t: +1-859-372-3244

Customer Service

t: +1-800-526-4960 t: +1-859-372-3214

e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road, Zhang Jiang Hi Tech Park

Shanghai 201203 PRC

Customer Service

t: +86 21 3861 9266 f: +86 21 3861 9599

e: info-engineeredmaterials-asia@celanese.com

Europa

Am Unisys-Park 1, 65843 Sulzbach, Germany

Product Information Service

t: +(00)-800-86427-531 t: +49-(0)-69-45009-1011

e: info-engineeredmaterials-eu@celanese.co

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Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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