Celanese
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HOSTAFORM® LX90GC15

HOSTAFORM®

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

Product information

Resin Identification	POM-GF15	ISO 1043
Part Marking Code	>POM-GF15<	ISO 11469

Rheological properties

Moulding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	5500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	75	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	4	%	ISO 527-1/-2
Flexural modulus	5200	MPa	ISO 178
Charpy notched impact strength, 23°C	4	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	4	kJ/m²	ISO 179/1eA
Poisson's ratio	0.35[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	155	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	161	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	50	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	100	E-6/K	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.85	%	Sim. to ISO 62
Density	1500	kg/m³	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	200	°C
Min. melt temperature	190	°C
Max. melt temperature	210	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	100	°C

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Min. mould temperature	80	°C
Max. mould temperature	120	°C
Hold pressure range	60 - 120	MPa
Back pressure	2	MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Specialty appearance

Additional information

Processing Notes

Pre-Drying

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

Storage

The product can then be stored in standard conditions until processed.

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