HOSTAFORM® LX90GC15

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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

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

Typical mechanical properties

Tensile modulus	798000	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	10900	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	4	%	ISO 527-1/-2
Flexural modulus	754000	psi	ISO 178
Charpy notched impact strength, 23°C	1.9	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	1.9	ftlb/in²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	311	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	322	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.28	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.556	E-4/°F	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	0.0542	lb/in³	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	392	°F
Min. melt temperature	374	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°F
Max. mold temperature	248	°F

Revised: 2024-07-08 Source: Celanese Materials Database

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Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	290	psi

Characteristics

Processing	Injection Molding
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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