HOSTAFORM® M90XAP®

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Hostaform® acetal copolymer grade M90XAP® is a low emission version, medium viscosity polymer providing optimum performance in injection molding, and primarily for the interior automotive market. This grade provides overall excellent performance in many applications.

Product information

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

Rheological properties

Melt volume-flow rate	8	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Molding shrinkage, normal	1.8	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	377000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	9400	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	9.5	%	ISO 527-1/-2
Flexural modulus	371000	psi	ISO 178
Flexural stress at 3.5%	10600	psi	ISO 178
Charpy notched impact strength, 23°C	3.04	$ftlb/in^2$	ISO 179/1eA
Izod notched impact strength, 23°C	2.57	$ftlb/in^2$	ISO 180/1A
Hardness, Rockwell, M-scale	78		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	212	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	315	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.67	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.667	E-4/°F	ISO 11359-1/-2

Electrical properties

Surface resistivity	1.3E16	Ohm	IEC 62631-3-2
Arc Resistance	240	s	UL 746B

Physical/Other properties

Density	0.0509	lb/in^3	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

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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
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	580	psi

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Changan	MTS-F01-02-001-A3	2019
Mercedes-Benz	DBL5410	

Characteristics

Processing	Injection Molding, Extrusion
Special characteristics	Low emissions

Additional information

Processing Notes

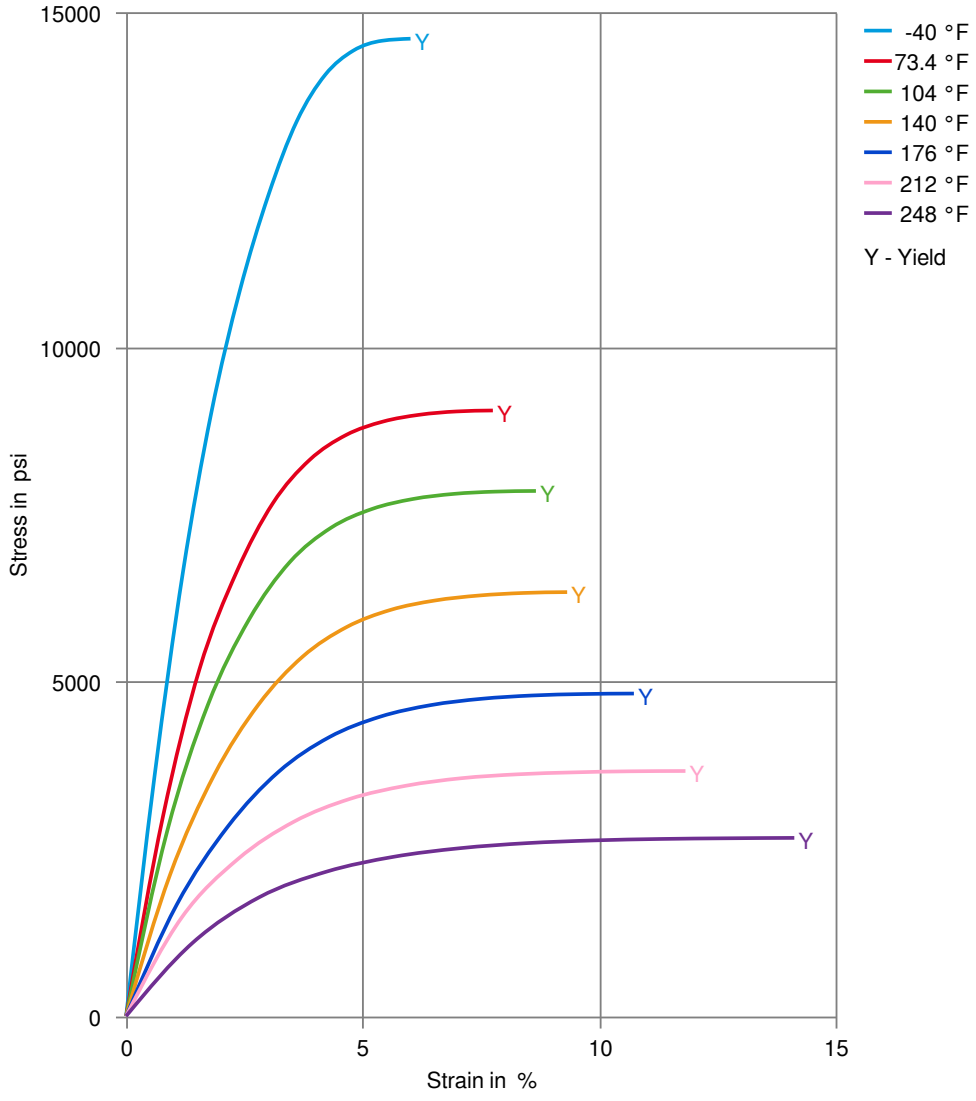
Pre-Drying

Drying is recommended to obtain optimum emission performance. If material contacts moisture through improper storage or handling, drying may be necessary to prevent splay and odor issues.

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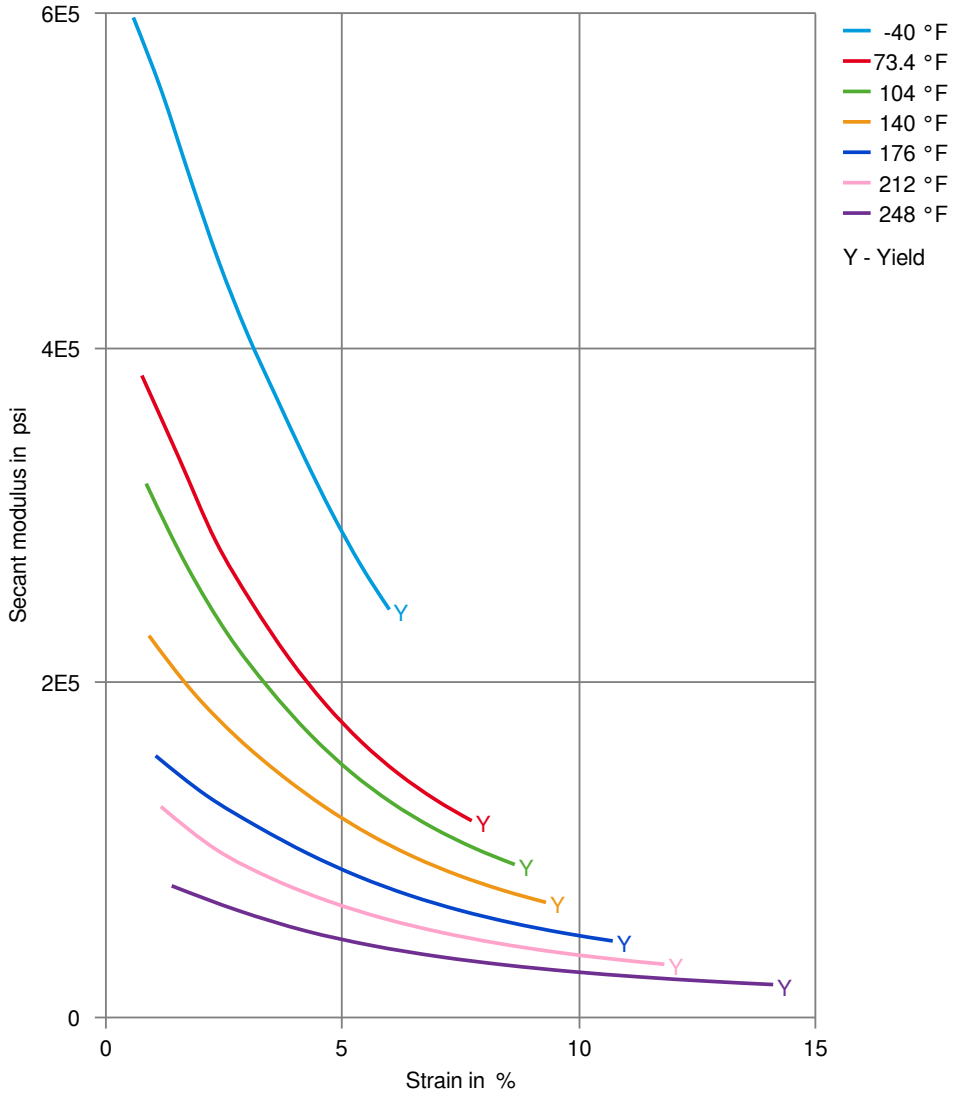
Stress-strain



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Secant modulus-strain



Revised: 2025-07-25 Source: Celanese Materials Database

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