Celanese
The chemistry inside innovation™

HOSTAFORM® LX90GC15

fiber glass coupled grade with molded in metallic appearance
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

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
Stress at break, 5mm/min	75	MPa	ISO 527-1/-2
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

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	155	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	161	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	50	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100	E-6/K	ISO 11359-1/-2

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 Temperature	100 - 120	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	0.15	%
Max. mould temperature	80 - 120	°C
Back pressure	2	MPa
Injection speed	slow	

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Characteristics

Additives	Release agent

Processing Texts

Pre-drying	Drying is required for this material to prevent poor appearance and performance of the part.
Longer pre-drying times/storage	The product can then be stored in standard conditions until processed.

Revised: 2023-02-23 Source: Celanese Materials Database