

HOSTAFORM® LX270

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Hostaform® LX270 specialty metallic appearance grades are an integrally colored nominal 27 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 Celanese Technical Service for assistance with your application.

Product information

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

Rheological properties

Melt volume-flow rate	24 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage range, parallel	2.1 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.8 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2700 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	56 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8 %	ISO 527-1/-2
Charpy notched impact strength, 23 °C	3 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.38 ^[C]	

[C]: Calculated

Thermal properties

Melting temperature, 10 °C/min	165 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	90 °C	ISO 75-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.75 %	Sim. to ISO 62
Density	1430 kg/m ³	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	190 °C
Min. melt temperature	180 °C
Max. melt temperature	195 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	90 °C
Min. mould temperature	80 °C
Max. mould temperature	105 °C
Hold pressure range	60 - 120 MPa

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Back pressure

4 MPa

Characteristics

Processing

Injection Moulding, Extrusion

Delivery form

Pellets

Additives

Release agent

Special characteristics

Specialty appearance, High Flow

Additional information

Processing Notes

Pre-Drying

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