

Hostaform® M90XAP®

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade M90 XAP® is a low emission version, medium viscosity polymer providing optimum performance in general purpose injection molding primarily for the interior automotive market. This grade provides overall excellent performance in many applications.

General Information			
UL YellowCard	E38860-239310		
Features	Low volatilization		
	General		
	Medium viscosity		
Uses	Application in Automobile Field		
	Car interior parts		
	General		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	1.8	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	65.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.5	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2560	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.4	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	100	°C	ISO 75-2/A
Melting Temperature ¹	167	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.2E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	

Drying Temperature	140	°C
Drying Time	2.0	hr
Rear Temperature	165 - 175	°C
Middle Temperature	170 - 180	°C
Front Temperature	170 - 180	°C
Nozzle Temperature	180 - 190	°C
Processing (Melt) Temp	180 - 190	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa
Injection instructions		
Manifold Temperature: 180 to 200°C Zone 4 Temperature: 175 to 185°C		
NOTE		
1.	10°C/min	

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