

Hostaform® LM140LG

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade LM140LG is a laser markable specialty grade of acetal copolymer formulated to provide good flow with a low gloss finish.

Preliminary Data Sheet

General Information			
Features	Gloss, low		
	Laser marking		
	Good liquidity		
RoHS Compliance		Contact manufacturer	
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	13.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1900	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	41.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.1	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	80.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	105 - 110	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 175	°C	
Middle Temperature	170 - 180	°C	
Front Temperature	175 - 185	°C	
Nozzle Temperature	185 - 195	°C	
Processing (Melt) Temp	180 - 195	°C	
Mold Temperature	80.0 - 105	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 0.500	MPa	

Injection instructions

Zone 4 Temperature: 180 to 190°C

NOTE

1. 10°C/min

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