

# Hostaform® M90LF

Acetal (POM) Copolymer

Celanese Corporation

## Message:

Hostaform® acetal copolymer grade M90LF is a medium viscosity polymer providing optimum performance in general purpose injection molding and extrusion of thin walled tubing and thin gauge film.

Preliminary Data Sheet

| General Information                               |                      |                        |                 |
|---------------------------------------------------|----------------------|------------------------|-----------------|
| UL YellowCard                                     | E38860-239310        |                        |                 |
| Features                                          | General              |                        |                 |
|                                                   | Medium viscosity     |                        |                 |
| Uses                                              | Thin wall parts      |                        |                 |
|                                                   | Films                |                        |                 |
|                                                   | Pipe fittings        |                        |                 |
| RoHS Compliance                                   | Contact manufacturer |                        |                 |
| Processing Method                                 | Extrusion            |                        |                 |
|                                                   | Injection molding    |                        |                 |
| Physical                                          | Nominal Value        | Unit                   | Test Method     |
| Density                                           | 1.41                 | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)       | 8.00                 | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage                                 |                      |                        | ISO 294-4       |
| Vertical flow direction                           | 1.9                  | %                      | ISO 294-4       |
| Flow direction                                    | 2.0                  | %                      | ISO 294-4       |
| Mechanical                                        | Nominal Value        | Unit                   | Test Method     |
| Tensile Modulus                                   | 2800                 | MPa                    | ISO 527-2/1A/1  |
| Tensile Stress (Yield)                            | 66.0                 | MPa                    | ISO 527-2/1A/50 |
| Tensile Strain (Yield)                            | 9.0                  | %                      | ISO 527-2/1A/50 |
| Impact                                            | Nominal Value        | Unit                   | Test Method     |
| Charpy Notched Impact Strength (23°C)             | 6.0                  | kJ/m <sup>2</sup>      | ISO 179/1eA     |
| Thermal                                           | Nominal Value        | Unit                   | Test Method     |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 101                  | °C                     | ISO 75-2/A      |
| Melting Temperature <sup>1</sup>                  | 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     | 80.0 - 100    | °C   |
| Drying Time            | 3.0           | hr   |
| Rear Temperature       | 170 - 180     | °C   |
| Middle Temperature     | 180 - 190     | °C   |
| Front Temperature      | 180 - 190     | °C   |
| Nozzle Temperature     | 190 - 200     | °C   |
| Processing (Melt) Temp | 180 - 200     | °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

Zone 4 Temperature: 190 to 200°C

#### NOTE

1. 10°C/min

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