

HOSTAFORM® M90XAP® | POM | Unfilled

Description

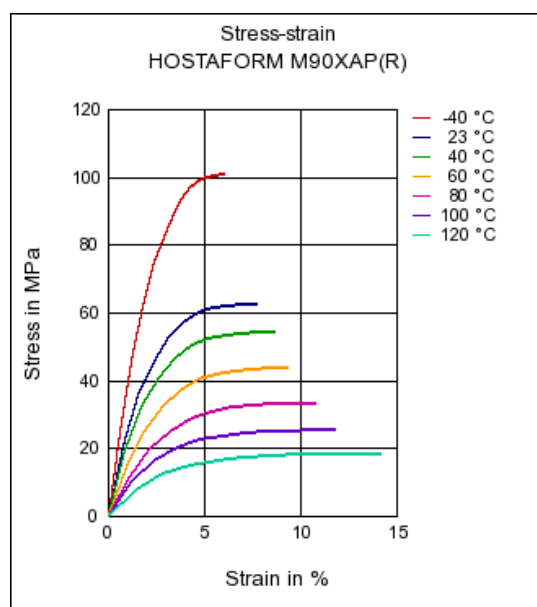
Hostaform® acetal copolymer grade M90 XAP® is a low emission version, medium viscosity polymer providing optimum performance in general purpose injection molding primarily for the interior automotive market. This grade provides overall excellent performance in many applications.

Physical properties	Value	Unit	Test Standard
Density	1400	kg/m ³	ISO 1183
Melt volume rate (MVR)	8	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	1.8	%	ISO 294-4
Mold shrinkage - normal	1.8	%	ISO 294-4

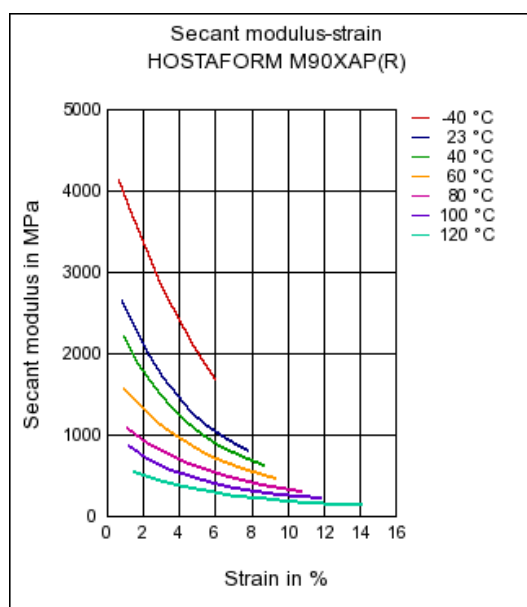
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2600	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	65	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	9.5	%	ISO 527-2/1A
Flexural modulus (23°C)	2560	MPa	ISO 178
Charpy notched impact strength @ 23°C	6.4	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	167	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	100	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	1.2	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	1.2	E-4/°C	ISO 11359-2

Stress-strain



Secant modulus-strain



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Typical injection moulding processing conditions



Pre Drying:

Drying is recommended to obtain optimum emission performance. If material contacts moisture through improper storage or handling, drying may be necessary to prevent splay and odor issues.

Drying time: 2 h

Drying temperature: 140 -- °C

Temperature:

	ϕ Manifold	ϕ Mold	ϕ Melt	ϕ Nozzle	ϕ Zone4	ϕ Zone3	ϕ Zone2	ϕ Zone1
min (°C)	180	80	180	180	175	170	170	165
max (°C)	200	120	190	190	185	180	180	175

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	5

Speed:

Injection speed: slow-medium

Special Info:

Recommended shot size is on the order of half the maximum shot size for your machine to ensure short residence time.

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General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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