

HOSTAFORM® LX270

improved flow general purpose unfilled molded in metallic appearance

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.

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
Yield stress, 50mm/min	56 MPa	ISO 527-1/-2
Yield strain, 50mm/min	8 %	ISO 527-1/-2
Charpy notched impact strength, 23 °C	3 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10 °C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	90 °C	ISO 75-1/-2

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 Temperature	100 - 120 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Max. mould temperature	80 - 105 °C
Back pressure	4 MPa
Injection speed	slow

Characteristics

Additives	Release agent
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Processing Texts

Pre-drying

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

