

HOSTAFORM® M90XAP®

Low emission grade based on Celcon M90™ for interior automotive

Hostaform® acetal copolymer grade M90XAP® 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.

Rheological properties

Melt volume-flow rate	8 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage range, parallel	1.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.8 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2600 MPa	ISO 527-1/-2
Yield stress, 50mm/min	65 MPa	ISO 527-1/-2
Yield strain, 50mm/min	9.5 %	ISO 527-1/-2
Flexural Modulus	2560 MPa	ISO 178
Flexural Stress at 3.5%	73 MPa	ISO 178
Charpy notched impact strength, 23°C	6.4 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.4 kJ/m ²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	157 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	160 °C	ISO 306
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2

Other properties

Density	1410 kg/m ³	ISO 1183
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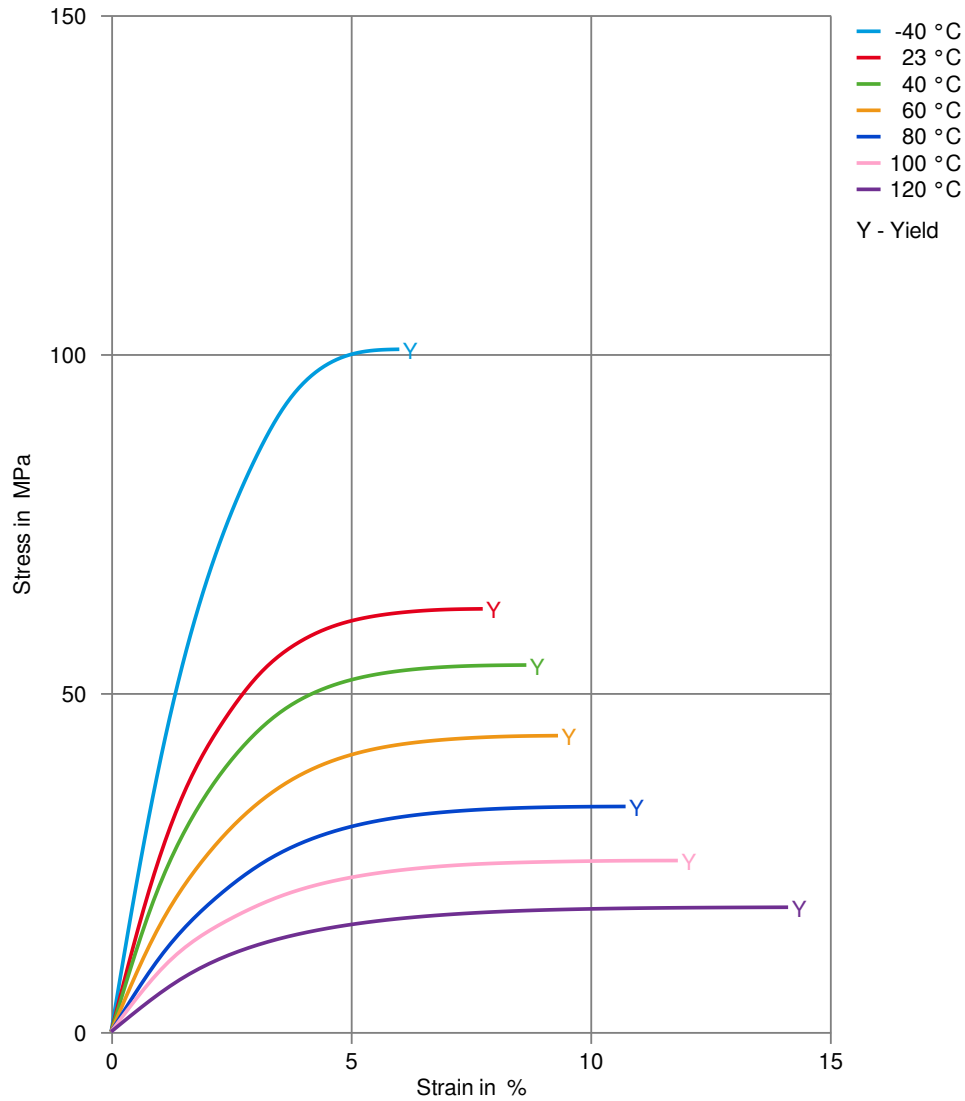
Injection

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



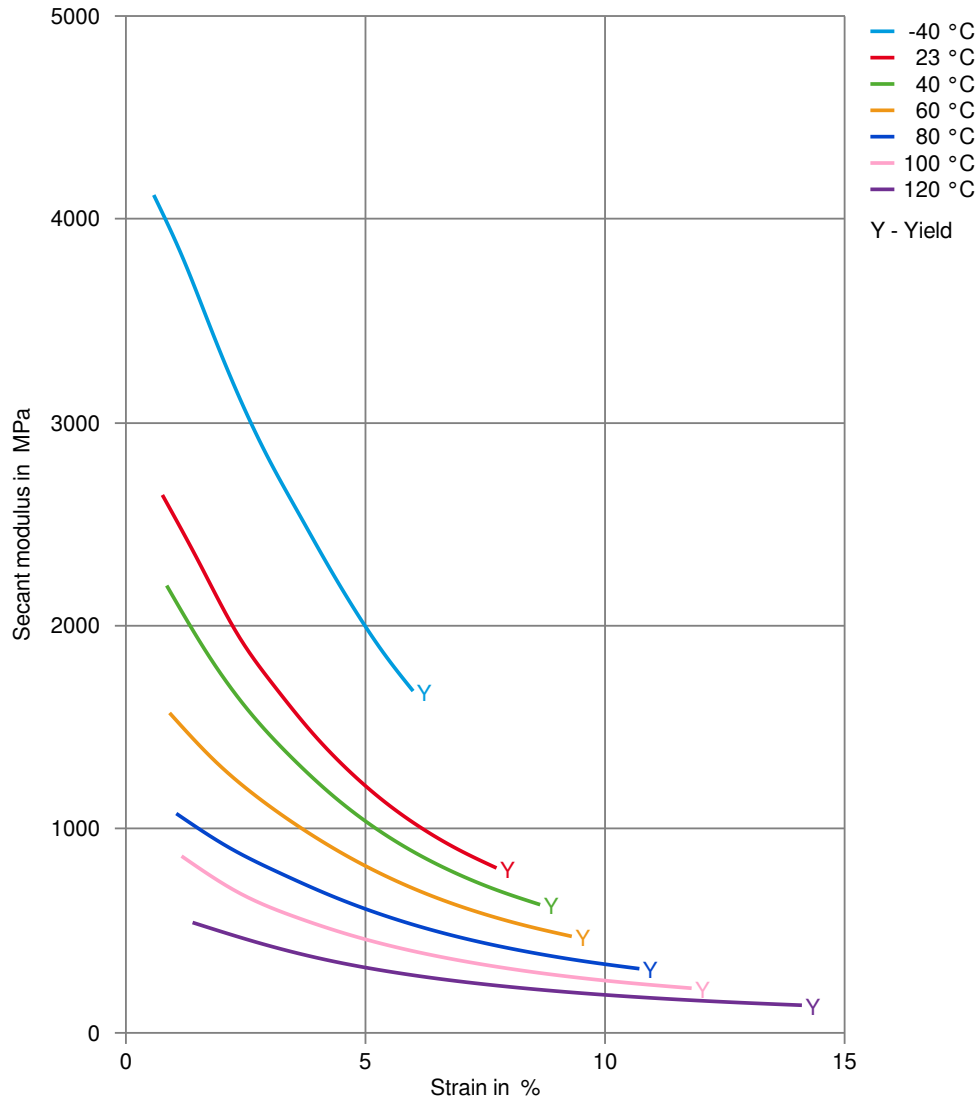
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Stress-strain



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Secant modulus-strain



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Processing Texts

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.

Other Approvals

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OEM	Specification	Additional Information
Changan	MTS-F01-02-001-A3	2019
Mercedes-Benz Group (Daimler)	DBL 5410	
Toyota	TSM5515G-1BV	

