

Hostaform® C 13021 XAP²™

Acetal (POM) Copolymer

Celanese Corporation

Message:

POM copolymer

Medium flow injection molding grade with reduced emissions especially for automotive interior application.

Burning rate according to FMVSS 302 < 100 mm/min (1 mm thickness)

Emission according to VDA 275 < 2 mg/kg (natural grades)

Emission according to VDA 275 < 5 mg/kg (colored grades)

Preliminary Datasheet

General Information			
Features	Low volatilization		
	Medium liquidity		
Uses	Application in Automobile Field		
	Car interior parts		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12.0	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2750	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	64.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	25	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	2400	MPa	ISO 899-1
1000 hr	1200	MPa	ISO 899-1
Flexural Modulus (23°C)	2700	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m ²	ISO 179/1eA
23°C	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	140	kJ/m ²	ISO 179/1eU
23°C	150	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method

Melting Temperature ¹	166	°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
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength	35	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.00		IEC 60250
1 MHz	4.00		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	2.0E-3		IEC 60250
1 MHz	5.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	170 - 175	°C	
Middle Temperature	180 - 185	°C	
Front Temperature	180 - 195	°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 - 4.00	MPa	
Screw L/D Ratio	15.0:1.0 to 25.0:1.0		
Injection instructions			
Manifold Temperature: 190 to 200°CZone 4 Temperature: 180 to 200°CFeed Temperature: 60 to 80°C			
NOTE			
1.	10°C/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

