

# Hostaform® S 27063 XAP<sup>2</sup>™

Acetal (POM) Copolymer

Celanese Corporation

## Message:

POM copolymer, impact modified

Easy flowing elastomer-containing injection molding type based on

HOSTAFORM C 27021; with higher impact strength and reduced emissions.

Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for more than 1 mm thickness.

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

Ranges of applications: For thin-walled molded parts with higher energy-absorbing capacity

Preliminary datasheet

| General Information                         |                         |                        |                 |
|---------------------------------------------|-------------------------|------------------------|-----------------|
| Additive                                    | Impact modifier         |                        |                 |
| Features                                    | Impact modification     |                        |                 |
|                                             | Low volatilization      |                        |                 |
|                                             | Impact resistance, high |                        |                 |
|                                             | Good liquidity          |                        |                 |
| Uses                                        | Thin wall parts         |                        |                 |
| RoHS Compliance                             | Contact manufacturer    |                        |                 |
| Processing Method                           | Injection molding       |                        |                 |
| Physical                                    | Nominal Value           | Unit                   | Test Method     |
| Density                                     | 1.39                    | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (190°C/2.16 kg) | 20.0                    | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage                           |                         |                        | ISO 294-4       |
| Vertical flow direction                     | 1.8                     | %                      | ISO 294-4       |
| Flow direction                              | 1.9                     | %                      | ISO 294-4       |
| Water Absorption (Saturation, 23°C)         | 0.65                    | %                      | ISO 62          |
| Mechanical                                  | Nominal Value           | Unit                   | Test Method     |
| Tensile Modulus                             | 2200                    | MPa                    | ISO 527-2/1A/1  |
| Tensile Stress (Yield)                      | 54.0                    | MPa                    | ISO 527-2/1A/50 |
| Tensile Strain (Yield)                      | 9.0                     | %                      | ISO 527-2/1A/50 |
| Nominal Tensile Strain at Break             | 30                      | %                      | ISO 527-2/1A/50 |
| Tensile Creep Modulus                       |                         |                        | ISO 899-1       |
| 1 hr                                        | 1850                    | MPa                    | ISO 899-1       |
| 1000 hr                                     | 1050                    | MPa                    | ISO 899-1       |
| Flexural Modulus (23°C)                     | 2100                    | MPa                    | ISO 178         |
| Impact                                      | Nominal Value           | Unit                   | Test Method     |
| Charpy Notched Impact Strength              |                         |                        | ISO 179/1eA     |
| -30°C                                       | 6.0                     | kJ/m <sup>2</sup>      | ISO 179/1eA     |

|                                                                                                |               |                   |             |
|------------------------------------------------------------------------------------------------|---------------|-------------------|-------------|
| 23°C                                                                                           | 9.0           | kJ/m <sup>2</sup> | ISO 179/1eA |
| Charpy Unnotched Impact Strength                                                               |               |                   | ISO 179/1eU |
| -30°C                                                                                          | 90            | kJ/m <sup>2</sup> | ISO 179/1eU |
| 23°C                                                                                           | 140           | kJ/m <sup>2</sup> | ISO 179/1eU |
| Thermal                                                                                        | Nominal Value | Unit              | Test Method |
| Heat Deflection Temperature (1.8 MPa, Unannealed)                                              | 84.0          | °C                | ISO 75-2/A  |
| Melting Temperature <sup>1</sup>                                                               | 166           | °C                | ISO 11357-3 |
| CLTE - Flow                                                                                    | 1.2E-4        | cm/cm/°C          | ISO 11359-2 |
| Electrical                                                                                     | Nominal Value | Unit              | Test Method |
| Surface Resistivity                                                                            | 1.0E+13       | ohms              | IEC 60093   |
| Volume Resistivity                                                                             | 1.0E+13       | ohms·cm           | IEC 60093   |
| Dielectric Strength                                                                            | 28            | kV/mm             | IEC 60243-1 |
| Relative Permittivity                                                                          |               |                   | IEC 60250   |
| 100 Hz                                                                                         | 4.20          |                   | IEC 60250   |
| 1 MHz                                                                                          | 4.20          |                   | IEC 60250   |
| Dissipation Factor                                                                             |               |                   | IEC 60250   |
| 100 Hz                                                                                         | 5.0E-3        |                   | IEC 60250   |
| 1 MHz                                                                                          | 0.015         |                   | IEC 60250   |
| Comparative Tracking Index                                                                     | 600           | V                 | IEC 60112   |
| Injection                                                                                      | Nominal Value | Unit              |             |
| Drying Temperature                                                                             | 100 - 120     | °C                |             |
| Drying Time                                                                                    | 3.0 - 4.0     | hr                |             |
| Suggested Max Moisture                                                                         | 0.15          | %                 |             |
| Hopper Temperature                                                                             | 20.0 - 30.0   | °C                |             |
| Rear Temperature                                                                               | 170 - 180     | °C                |             |
| Middle Temperature                                                                             | 180 - 190     | °C                |             |
| Front Temperature                                                                              | 190 - 200     | °C                |             |
| Nozzle Temperature                                                                             | 190 - 200     | °C                |             |
| Processing (Melt) Temp                                                                         | 190 - 200     | °C                |             |
| Mold Temperature                                                                               | 60.0 - 70.0   | °C                |             |
| Injection Pressure                                                                             | 60.0 - 120    | MPa               |             |
| Injection Rate                                                                                 | Slow-Moderate |                   |             |
| Holding Pressure                                                                               | 60.0 - 120    | MPa               |             |
| Back Pressure                                                                                  | 0.00 - 2.00   | MPa               |             |
| Injection instructions                                                                         |               |                   |             |
| Manifold Temperature: 190 to 200°CZone 4 Temperature: 190 to 200°CFeed Temperature: 60 to 80°C |               |                   |             |
| NOTE                                                                                           |               |                   |             |
| 1.                                                                                             | 10°C/min      |                   |             |

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