

Hostaform® C 2521 XAP²™

Acetal (POM) Copolymer

Celanese Corporation

Message:

POM copolymer

Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.

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 < 5 mg/kg (natural grades)

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

Preliminary Datasheet

General Information			
Features	Low volatilization		
	Solvent resistance		
	Impact resistance, high		
	Good liquidity		
	Good chemical resistance		
	alkali resistance		
	Fuel resistance		
	Hydrolysis resistance		
Uses	Application in Automobile Field		
	Car interior parts		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
	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)	2.50	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2450	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA

-30°C	7.0	kJ/m ²	ISO 179/1eA
23°C	8.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	200	kJ/m ²	ISO 179/1eU
23°C, local fracture	220	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	1.5E-3		IEC 60250
1 MHz	5.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Fill Analysis	Nominal Value	Unit	Test Method
Density of Melt	1.200	g/cm ³	Internal method
Ejection Temperature	165	°C	Internal method
Specific Heat Capacity of Melt	2210	J/kg/°C	Internal method
Thermal Conductivity of Melt	0.16	W/m/K	Internal method
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 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	190 - 200	°C	
Nozzle Temperature	190 - 210	°C	
Processing (Melt) Temp	190 - 210	°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 210°C Zone 4 Temperature: 190 to 210°C Feed Temperature: 60 to 80°C

NOTE

1. 10°C/min

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