

Hostaform® S 27242 XAP²™

Acetal (POM) Copolymer

Celanese Corporation

Message:

Easy flow, impact modified injection molding grade, with good low temperature impact strength and good weld line strength and reduced emissions.

Emission according to VDA 275 < 5 mg/kg

Preliminary data sheet

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Low volatilization		
	Good liquidity		
	Low temperature impact resistance		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	17.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2150	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	8.5	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	40	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.5	kJ/m ²	ISO 179/1eA
23°C	6.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	130	kJ/m ²	ISO 179/1eU
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 - 80.0	°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

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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

