

Hostaform® S 27064 XAP²™

Acetal (POM) Copolymer

Celanese Corporation

Message:

Polyacetal copolymer, impact modified

Easy flowing, elastomer-containing injection molding type based on HOSTAFORM C 27021 with high toughness and reduced emissions

HB. 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 colored grades)

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

Preliminary datasheet

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Low volatilization		
	Good liquidity		
	Good toughness		
Uses	Thin wall parts		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	18.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.7	%	ISO 294-4
Flow direction	1.8	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1700	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	44.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	1400	MPa	ISO 899-1
1000 hr	800	MPa	ISO 899-1
Flexural Modulus (23°C)	1700	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	11	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	110	kJ/m ²	ISO 179/1eU
23°C, local fracture	150	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	77.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
CLTE - Flow	1.3E-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	4.40		IEC 60250
1 MHz	4.40		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	0.010		IEC 60250
1 MHz	0.020		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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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

