

HOSTAFORM® C 27021 XAP® 2 LS

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Polyacetalcopolymer Easy flow injection molding grade with reduced emissions especially for automotive interior application. With Improved UV resistance Burning rate according to FMVSS 302 < 100 mm/min (1 mm thickness) Emission according to VDA 275 < 5 mg/kg.

Product information

Resin Identification	POM	ISO 1043
Part Marking Code	>POM<	ISO 11469

Rheological properties

Melt volume-flow rate	24 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage, parallel	2.1 %	ISO 294-4, 2577
Moulding shrinkage, normal	2.0 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2750 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	64 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	7.5 %	ISO 527-1/-2
Nominal strain at break	17 %	ISO 527-1/-2
Flexural modulus	2600 MPa	ISO 178
Tensile creep modulus, 1h	2400 MPa	ISO 899-1
Tensile creep modulus, 1000h	1200 MPa	ISO 899-1
Charpy impact strength, 23°C	170 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	170 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.37 ^[C]	

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Coefficient of linear thermal expansion (CLTE), parallel	110 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	110 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	4	IEC 62631-2-1
Dissipation factor, 100Hz	20 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	50 E-4	IEC 62631-2-1
Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	35 kV/mm	IEC 60243-1
Comparative tracking index	600	IEC 60112

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Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.65 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183

Injection

Drying Recommended	no
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Processing Moisture Content	≤0.2 %
Melt Temperature Optimum	190 °C
Min. melt temperature	180 °C
Max. melt temperature	200 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	80 °C
Max. mould temperature	120 °C
Hold pressure range	60 - 120 MPa
Back pressure	4 MPa

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	U.V. stabilised or stable to weather, High Flow, Low emissions

Additional information

Injection molding

Preprocessing

To achieve low emission values pre drying using a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,1 %

Processing

Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Postprocessing

Conditioning e.g. moisturizing is not necessary.

Processing Notes

Pre-Drying

recommended

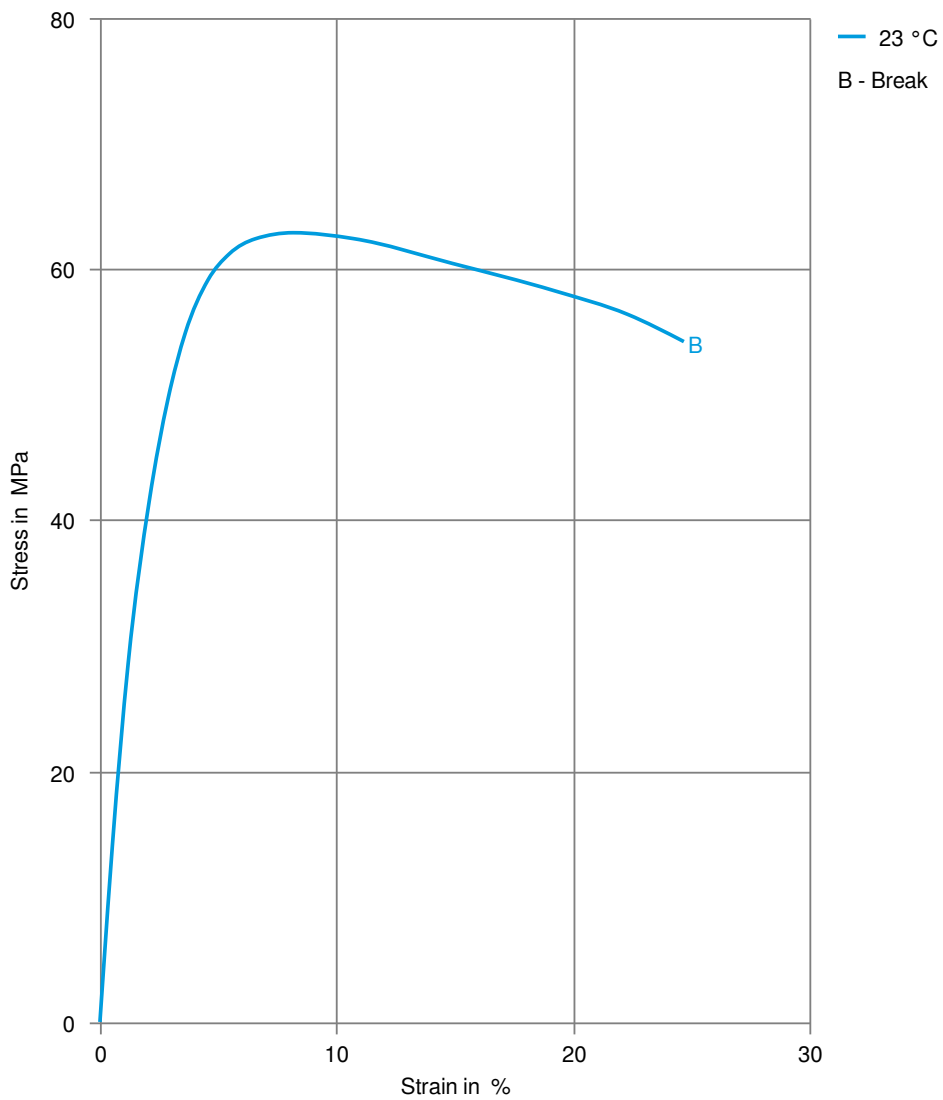
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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5404	BQF
Mercedes-Benz	DBL5410	
Renault	No Spec, Special Part Approval, See Your CE Account Manager.	
VW Group	TL 524 76	

Stress-strain



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Secant modulus-strain

