Hostaform® S 27064 XAP

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

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 <10 mg/kg (natural and colored grades) Ranges of applications: For thin-walled molded parts with high energy- absorbing capacity. Preliminary datasheet

General			
Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• Good Flow • High Energy Absorption	• High Toughness • Impact Modified	
Uses	• Thin-walled Parts		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	19	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.7	%	
Flow	1.8	%	
Water Absorption (Saturation, 73°F)	0.65	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.25	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	218000	psi	ISO 527-2/1A
Tensile Stress (Yield)	5950	psi	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
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.9	ft·lb/in²	
73°F	4.8	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	52	ft·lb/in²	
73°F, Partial Break	71	ft·lb/in²	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Ball Indentation Hardness [2]	13100	psi	ISO 2039-1
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	171	°F	ISO 75-2/A
Vicat Softening Temperature	257	°F	ISO 306/B50
Melting Temperature [3]	331	°F	ISO 11357-3
CLTE - Flow	7.2E-5	in/in/°F	ISO 11359-2

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Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms·cm	IEC 60093
Electric Strength	710	V/mil	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.40		
1 MHz	4.40		
Dissipation Factor			IEC 60250
100 Hz	0.010		
1 MHz	0.020		
Comparative Tracking Index	600	V	IEC 60112

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	374 to 392	°F
Mold Temperature	140 to 158	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 190 to 200°C
Hot runner temperature: 190 to 200°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 30s

[3] 10°C/min

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