

HOSTAFORM® C 27021 XAP®2

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Polyacetalcopolymer Easy flow injection molding grade 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 < 2 mg/kg (natural grades) Emission according to VDA 275 < 5 mg/kg (colored grades).

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 | |

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 | 164 °C | ISO 11357-1/-3 |
| Coefficient of linear thermal expansion (CLTE), parallel | 120 E-6/K | ISO 11359-1/-2 |
| Coefficient of linear thermal expansion (CLTE), normal | 120 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 | 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

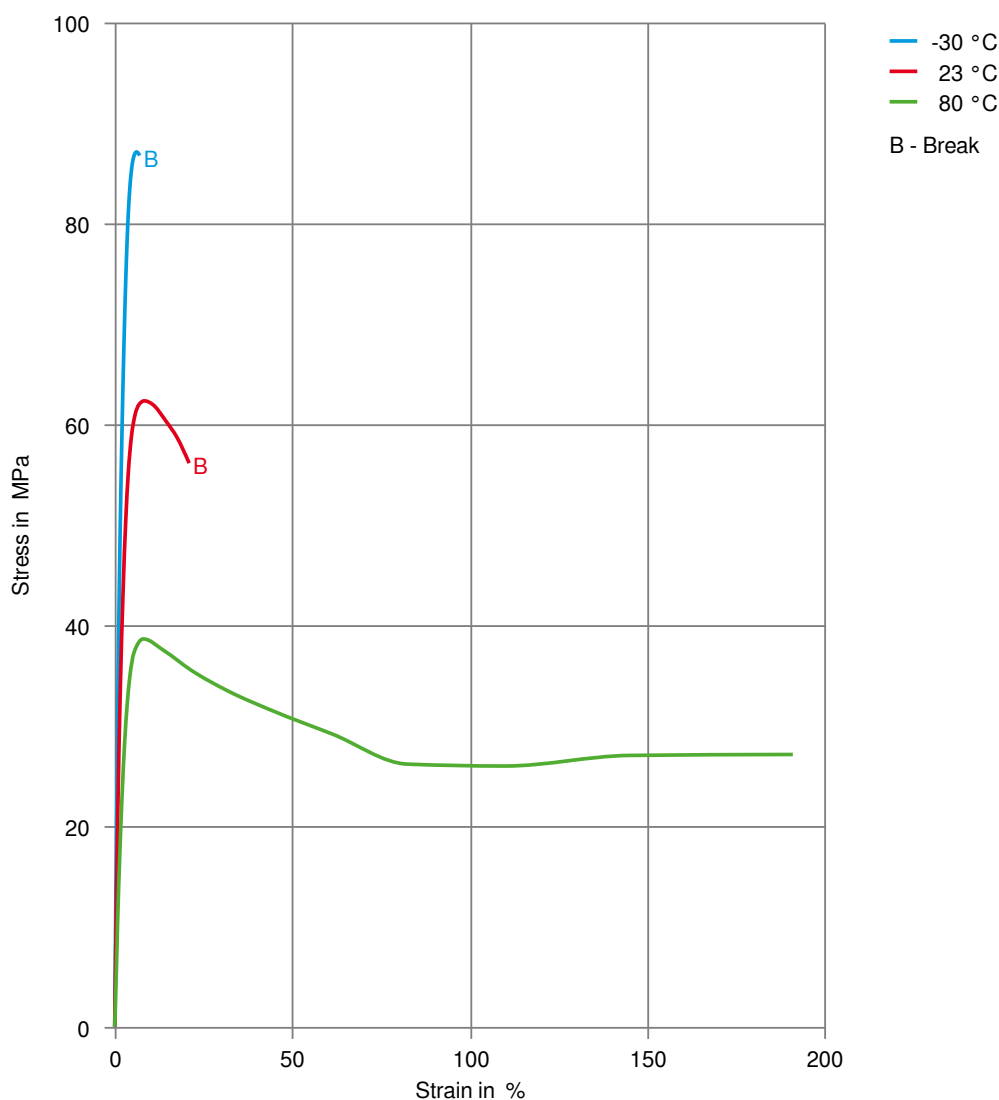
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Automotive

| OEM | STANDARD | ADDITIONAL INFORMATION |
|---------------|---|------------------------|
| Ford | WSK-M4D635-A3 | |
| Li Auto | Q/LiA5310020 | 2021 (V2) |
| Mercedes-Benz | DBL5404 | BQF |
| Mercedes-Benz | DBL5410 | |
| Renault | EP10-1c, No Spec, Special Part Approval, See Your CE Account Manager. | |
| VW Group | TL 524 76 | |

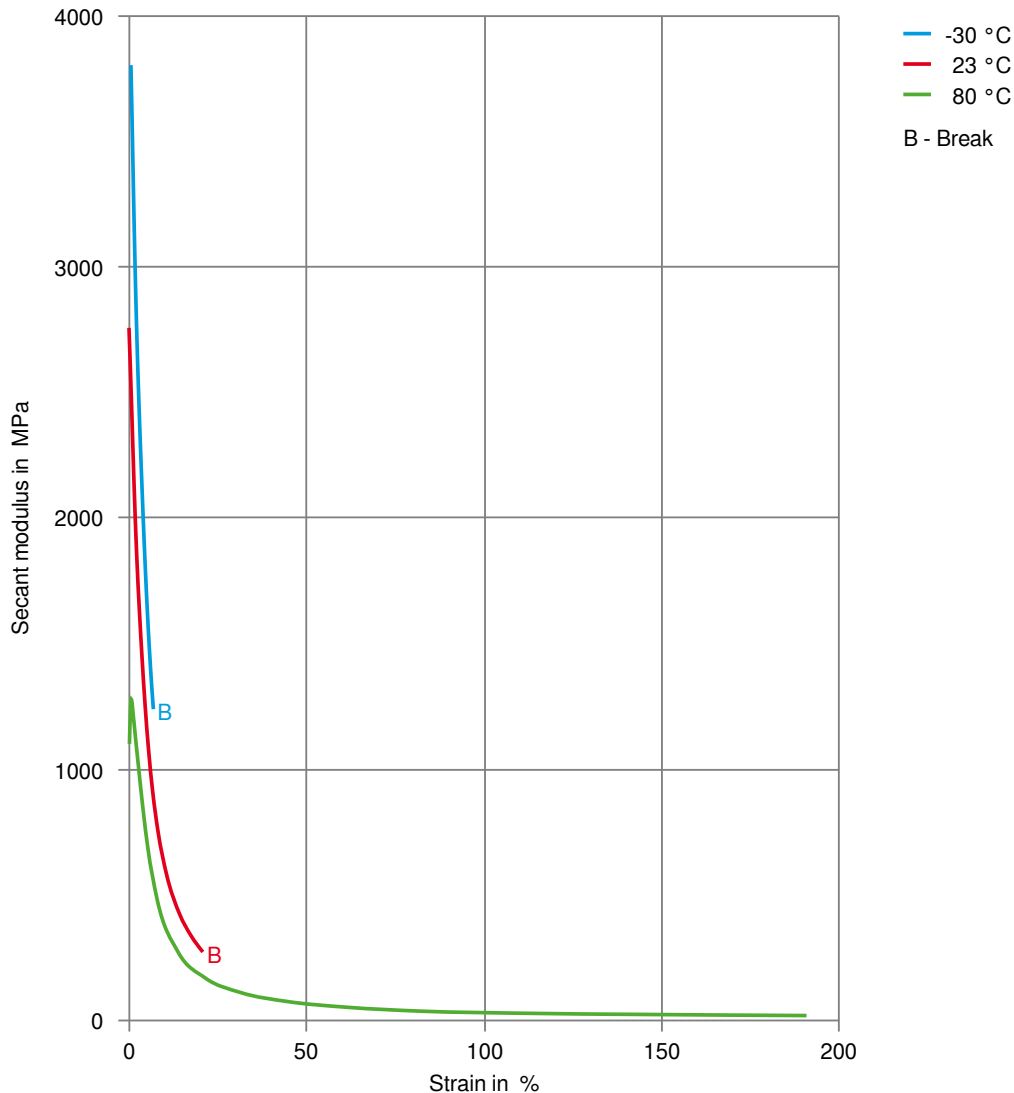
Stress-strain



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Secant modulus-strain



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