Celanese
The chemistry inside innovation™

HOSTAFORM® S 27242 XAP®2

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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

Product information

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

Rheological properties

Melt volume-flow rate	17	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile modulus	2100	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	50	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8.5	%	ISO 527-1/-2
Nominal strain at break	40	%	ISO 527-1/-2
Charpy impact strength, 23°C	130	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	7	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.4[C]		

[C]: Calculated

Physical/Other properties

Density	1360	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	195	°C
Min. melt temperature	190	°C
Max. melt temperature	200	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	70	°C
Min. mould temperature	60	°C
Max. mould temperature	80	°C
Hold pressure range	60 - 120	MPa
Back pressure	2	MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	High impact or impact modified, High Flow, Low emissions, Improved weld line

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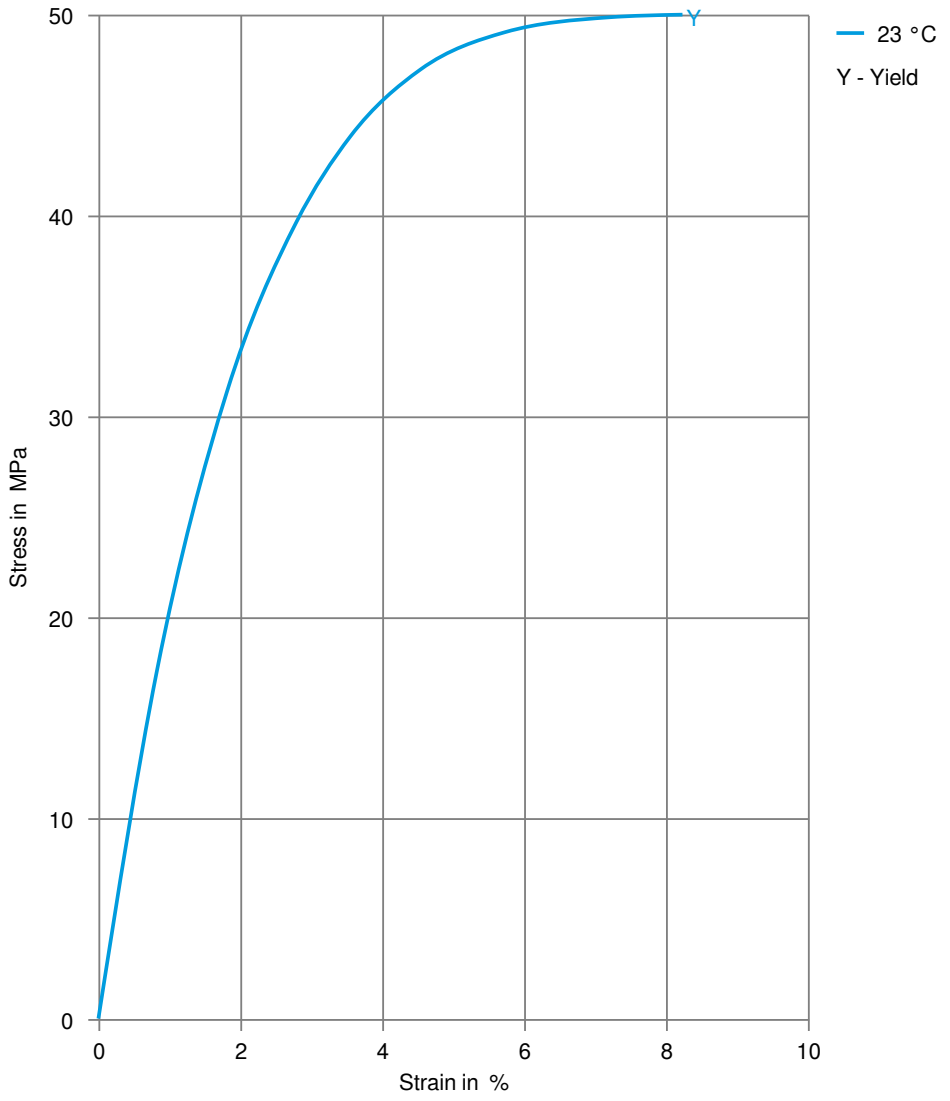
Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5404	BQF

Stress-strain



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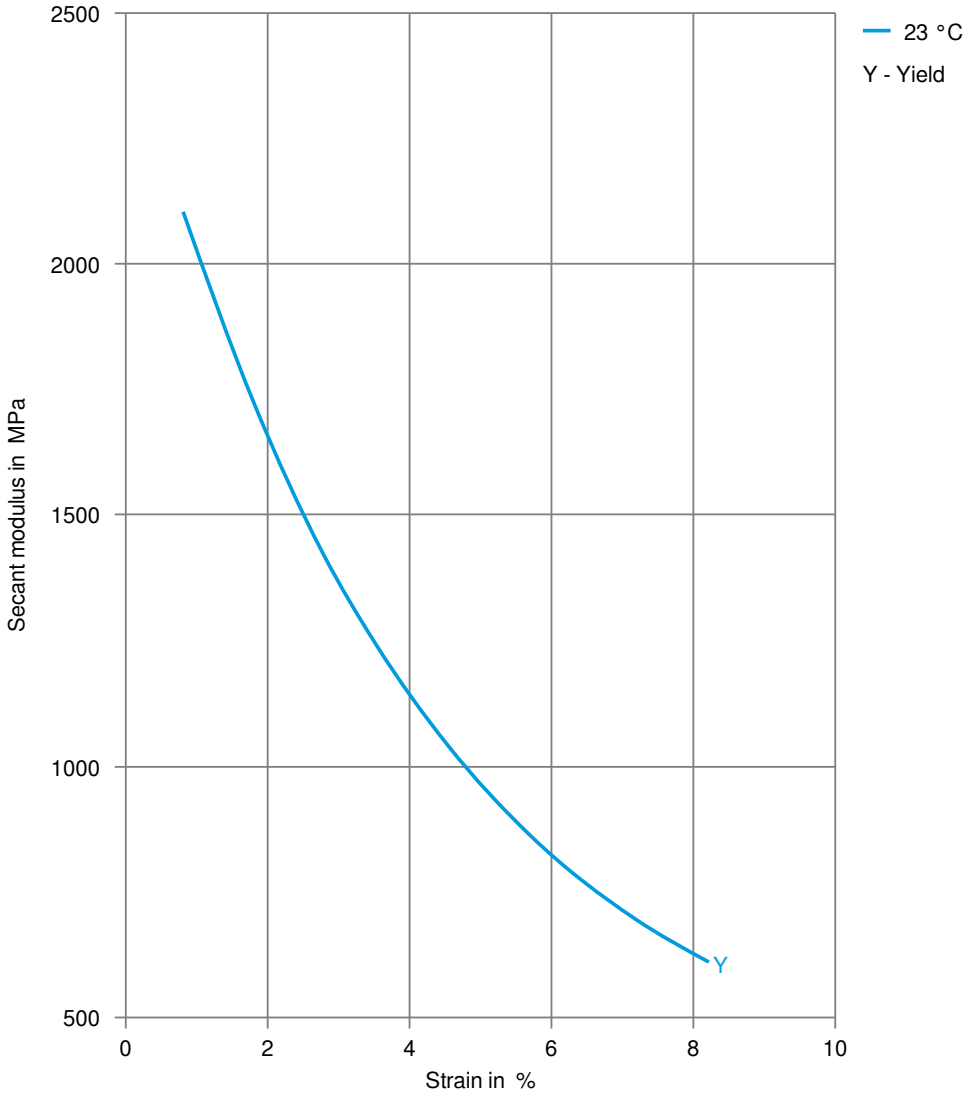
Secant modulus-strain



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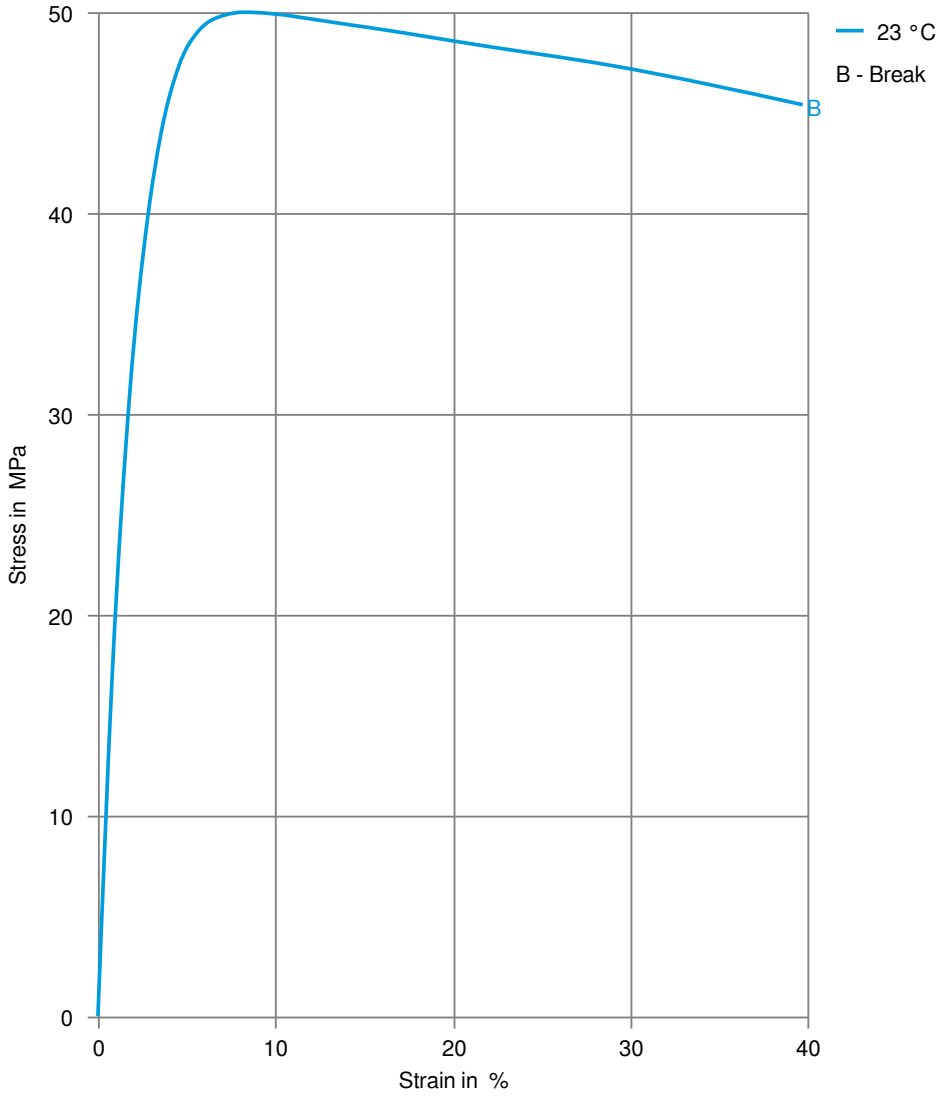
Stress-strain, 50mm/min



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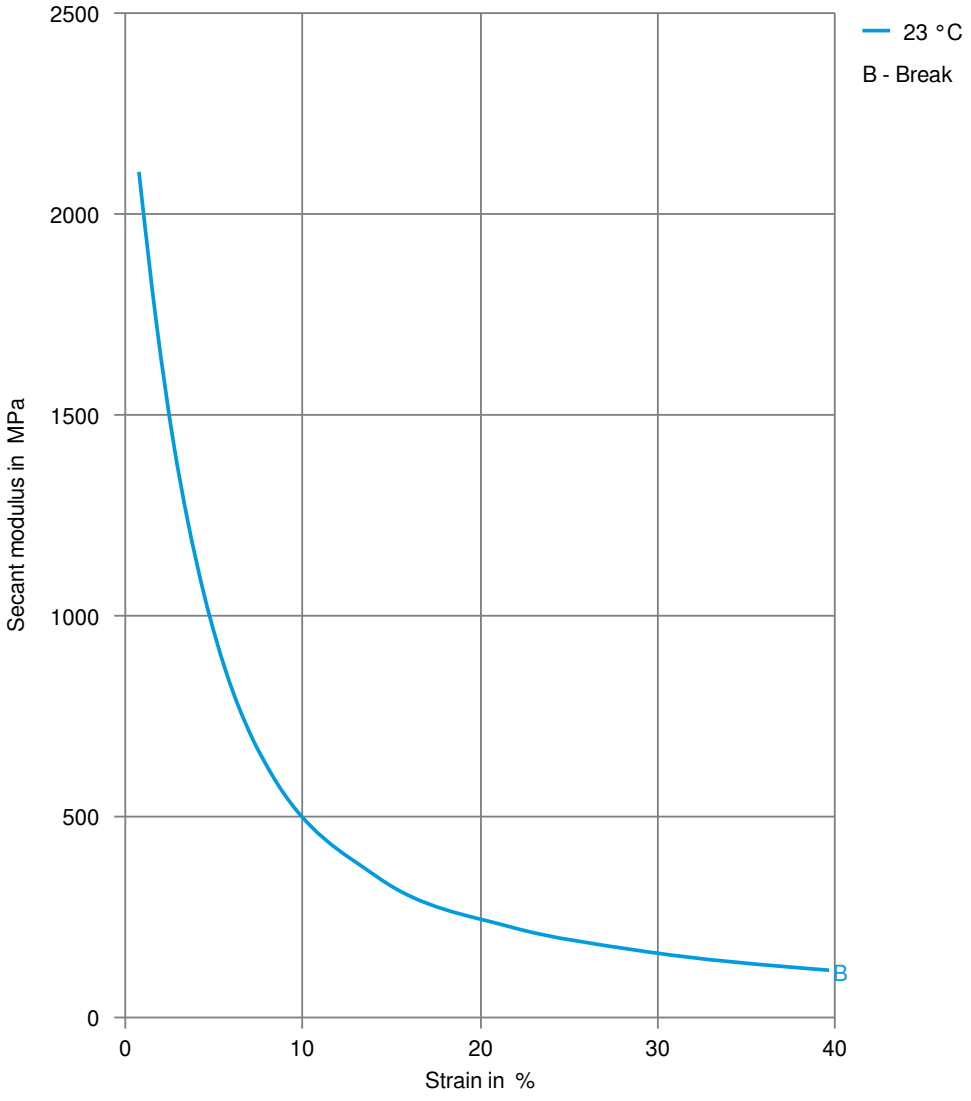
Secant modulus-strain, 50mm/min



Revised: 2024-12-03 Source: Celanese Materials Database