

# HOSTAFORM® S 27242 XAP®2

## HOSTAFORM®

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 <sup>3</sup> /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 <sup>2</sup> | ISO 179/1eU  |
| Charpy notched impact strength, 23 °C  | 7 kJ/m <sup>2</sup>   | ISO 179/1eA  |
| Charpy notched impact strength, -30 °C | 5.5 kJ/m <sup>2</sup> | ISO 179/1eA  |
| Poisson's ratio                        | 0.4 <sup>[C]</sup>    |              |

[C]: Calculated

### Physical/Other properties

|         |                        |          |
|---------|------------------------|----------|
| Density | 1360 kg/m <sup>3</sup> | 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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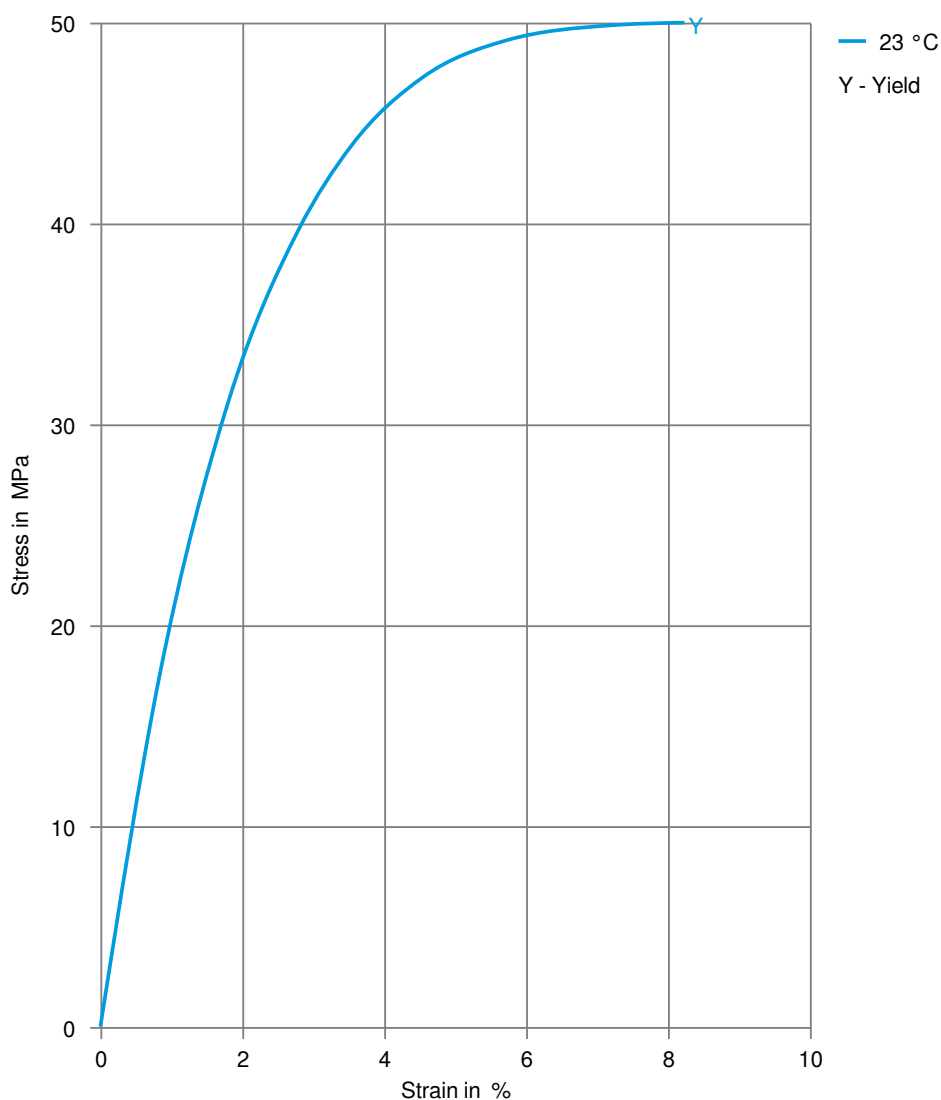
### Automotive

OEM  
Mercedes-Benz

STANDARD  
DBL5404

ADDITIONAL INFORMATION  
BQF

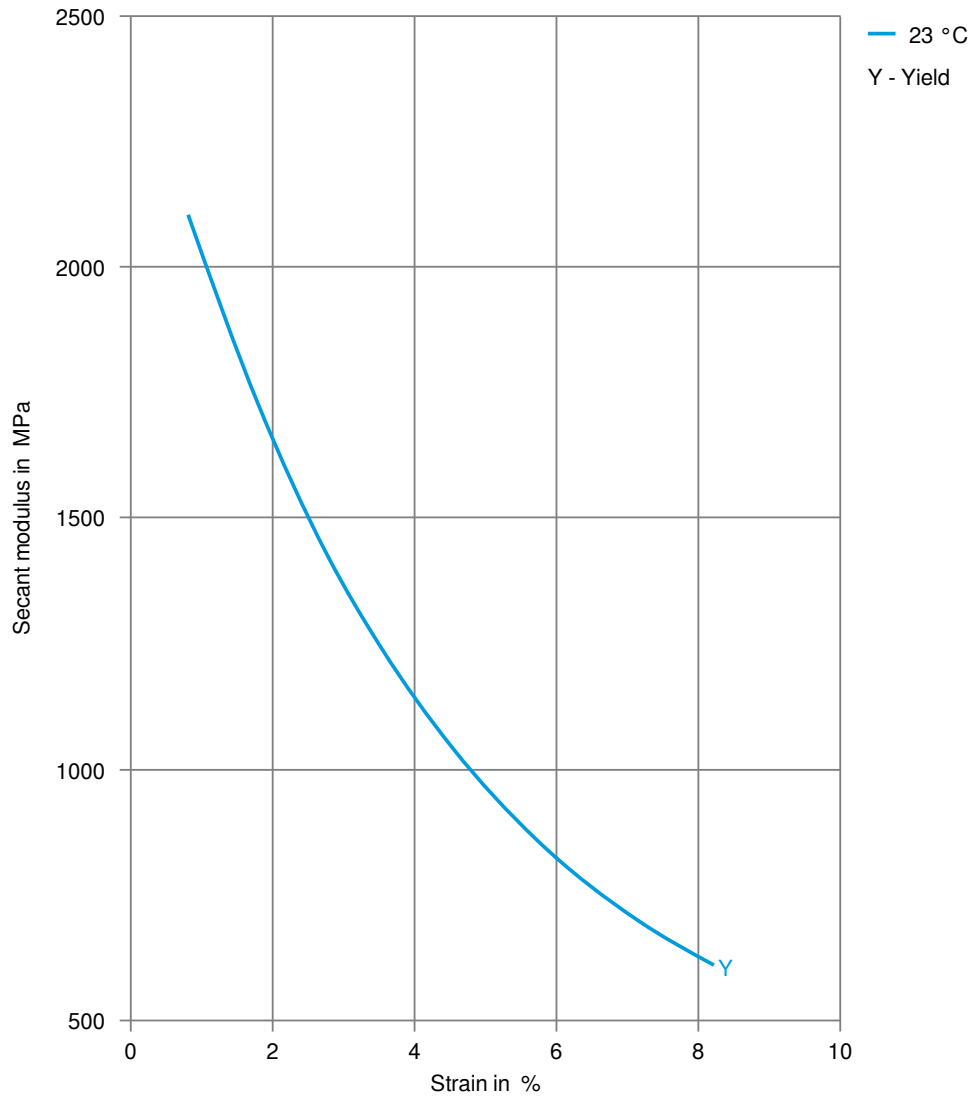
### Stress-strain



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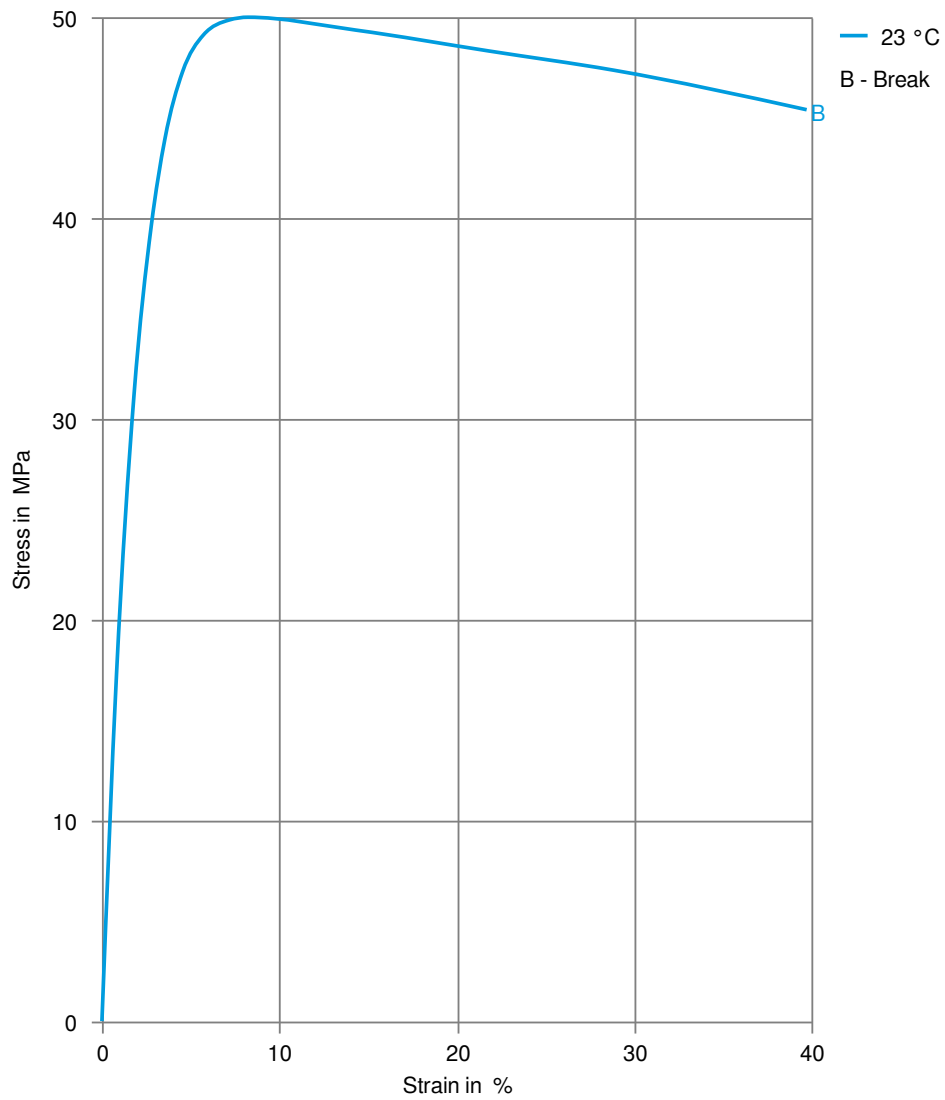
### Secant modulus-strain



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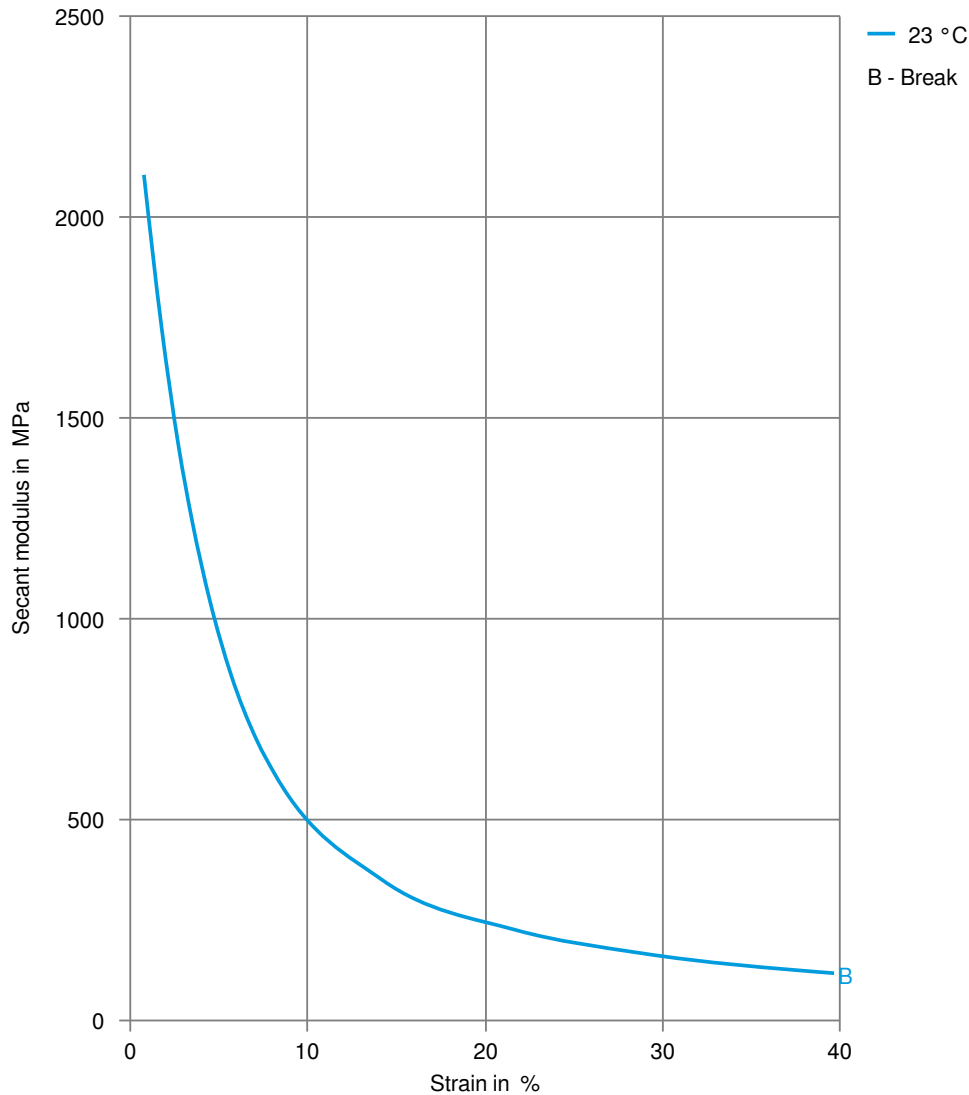
Stress-strain, 50mm/min



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Secant modulus-strain, 50mm/min



Printed: 2025-05-30

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

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