Celanese
The chemistry inside innovation™

HOSTAFORM® S 27244 XAP®2

HOSTAFORM®

Easy flow, high 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

Preliminary data sheet

Product information

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

Rheological properties

Melt volume-flow rate	4.5	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile modulus	1400	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	34	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8.5	%	ISO 527-1/-2
Nominal strain at break	50	%	ISO 527-1/-2
Charpy impact strength, 23°C	N	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	15	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	9	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.43[C]		

[C]: Calculated

Thermal properties

Temperature of deflection under load, 1.8 MPa	69	°C	ISO 75-1/-2

Physical/Other properties

Density	1260	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

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Characteristics

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

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5404	BQF

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