

# HOSTAFORM® S 9244 XAP® 2

## HOSTAFORM®

POM copolymer, modified Injection molding type, elastomer-containing; with higher impact strength and slightly lower hardness, rigidity and chemical resistance than unmodified acetal copolymer. Reduced emission grade, Emission according to VDA 275 < 5 mg/kg good weld strength. Preliminary Datasheet

### Product information

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

### Rheological properties

|                              |                            |                 |
|------------------------------|----------------------------|-----------------|
| Melt volume-flow rate        | 1.4 cm <sup>3</sup> /10min | ISO 1133        |
| Temperature                  | 190 °C                     |                 |
| Load                         | 2.16 kg                    |                 |
| Moulding shrinkage, parallel | 1.7 %                      | ISO 294-4, 2577 |
| Moulding shrinkage, normal   | 1.6 %                      | ISO 294-4, 2577 |

### Typical mechanical properties

|  |                                      |              |
|--|--------------------------------------|--------------|
| Tensile modulus                        | 1450 MPa                             | ISO 527-1/-2 |
| Tensile stress at yield, 50mm/min      | 33 MPa                               | ISO 527-1/-2 |
| Tensile strain at yield, 50mm/min      | 7 %                                  | ISO 527-1/-2 |
| Nominal strain at break                | >50 %                                | ISO 527-1/-2 |
| Flexural modulus                       | 1450 MPa                             | ISO 178      |
| Tensile creep modulus, 1h              | 1200 MPa                             | ISO 899-1    |
| Tensile creep modulus, 1000h           | 650 MPa                              | ISO 899-1    |
| Charpy impact strength, 23 °C          | N kJ/m <sup>2</sup>                  | ISO 179/1eU  |
| Charpy impact strength, -30 °C         | 200 <sup>[P]</sup> kJ/m <sup>2</sup> | ISO 179/1eU  |
| Charpy notched impact strength, 23 °C  | 18 kJ/m <sup>2</sup>                 | ISO 179/1eA  |
| Charpy notched impact strength, -30 °C | 12 kJ/m <sup>2</sup>                 | ISO 179/1eA  |
| Poisson's ratio                        | 0.43 <sup>[C]</sup>                  |              |

[P]: Partial Break

[C]: Calculated

### Thermal properties

|  |           |                |
|--|-----------|----------------|
| Melting temperature, 10 °C/min                           | 166 °C    | ISO 11357-1/-3 |
| Temperature of deflection under load, 1.8 MPa            | 68 °C     | ISO 75-1/-2    |
| Coefficient of linear thermal expansion (CLTE), parallel | 130 E-6/K | ISO 11359-1/-2 |

### Electrical properties

|                              |            |               |
|------------------------------|------------|---------------|
| Relative permittivity, 100Hz | 3.6        | IEC 62631-2-1 |
| Relative permittivity, 1MHz  | 3.6        | IEC 62631-2-1 |
| Dissipation factor, 100Hz    | 40 E-4     | IEC 62631-2-1 |
| Dissipation factor, 1MHz     | 60 E-4     | IEC 62631-2-1 |
| Volume resistivity           | 1E11 Ohm.m | IEC 62631-3-1 |
| Surface resistivity          | 1E13 Ohm   | IEC 62631-3-2 |
| 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    | 1.2 %                  | Sim. to ISO 62 |
| Density                  | 1260 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 | Low emissions, Improved weld line |

### Additional information

Injection molding

#### Processing

Above pressures, including back pressure, are given as specific or plastic pressures. The back pressure on Hostaform® and Celcon® POM materials should be as low as possible, just enough to remove air from the pellets during feeding.

Processing Notes

#### Pre-Drying

It is normally not necessary to dry HOSTAFORM. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required. A circulating air drying cabinet can be used for this purpose

#### Storage

The product can then be stored in standard conditions until processed.

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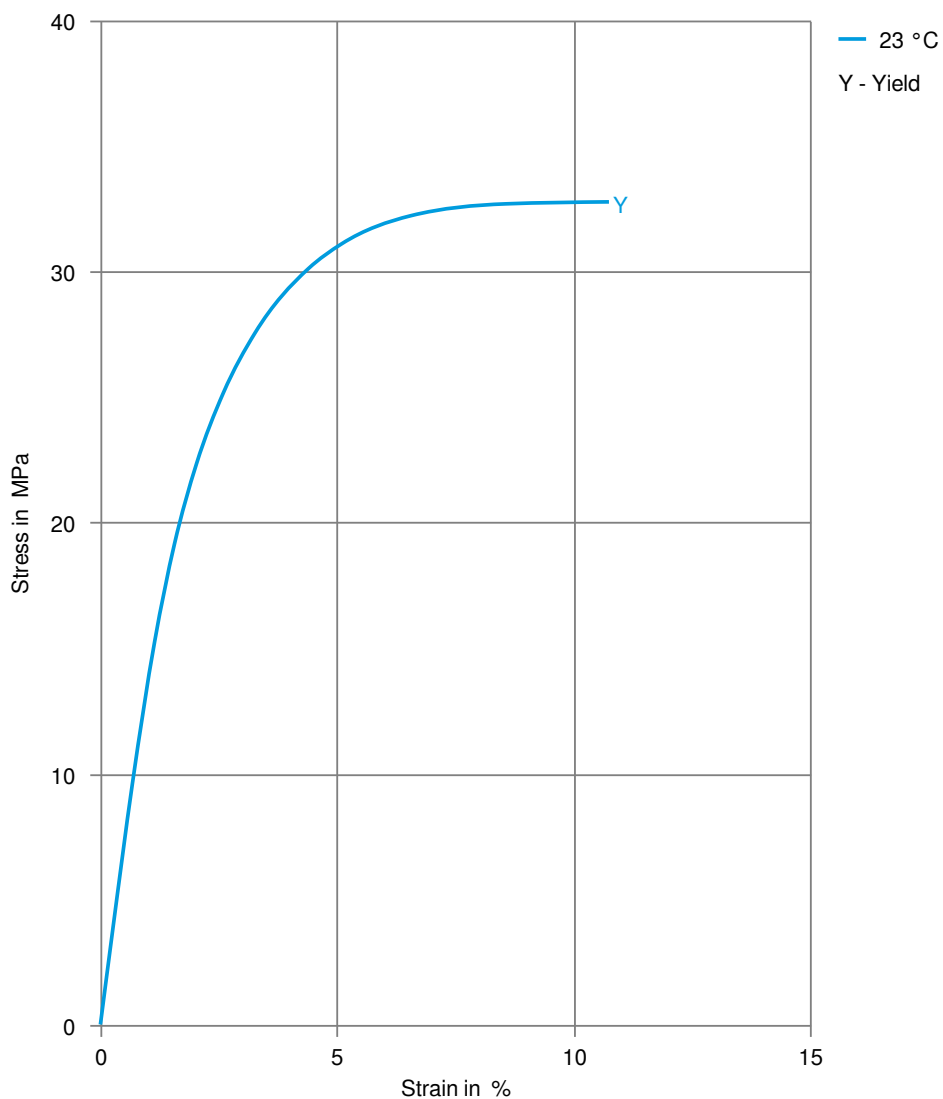
### Automotive

OEM  
Mercedes-Benz  
Renault

STANDARD  
DBL5404  
UB15, No Spec, Special Part Approval, See  
Your CE Account Manager.

ADDITIONAL INFORMATION  
BQF

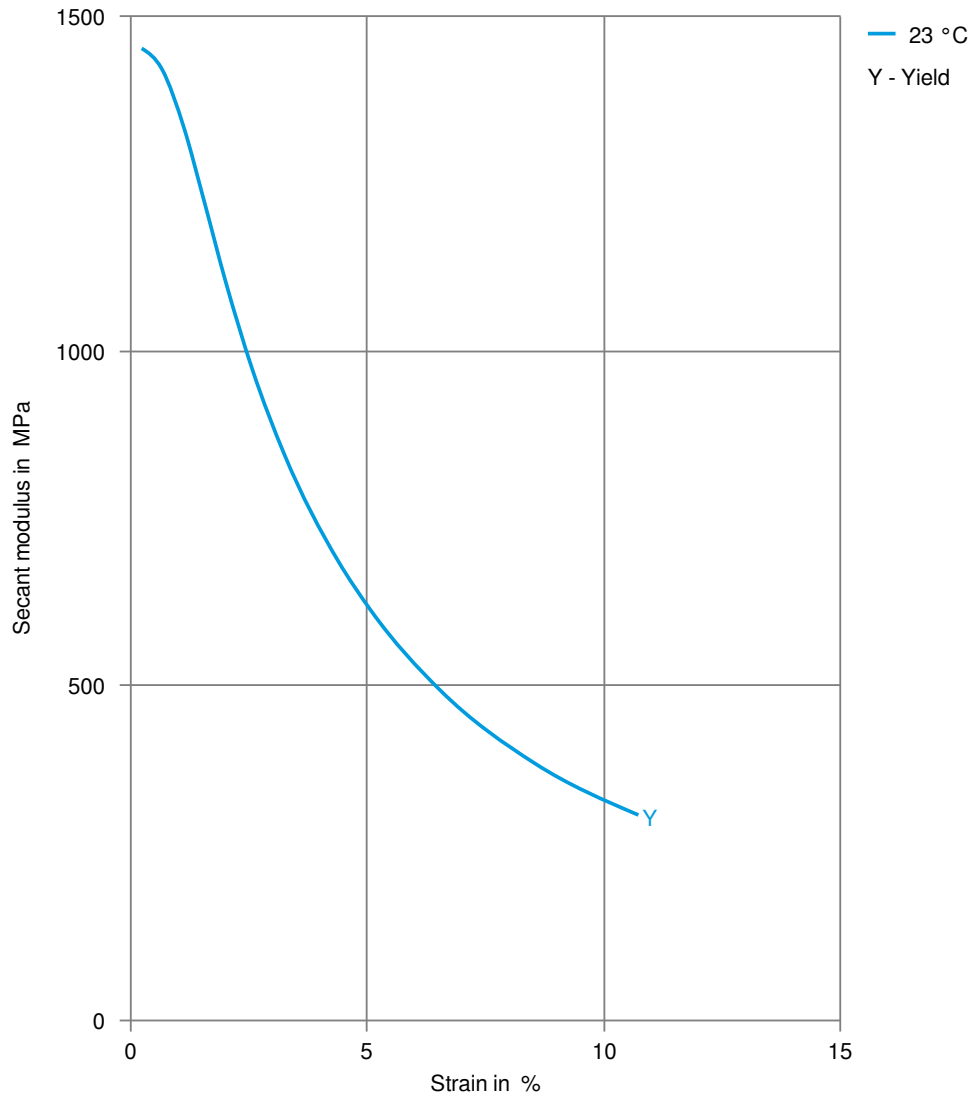
### Stress-strain



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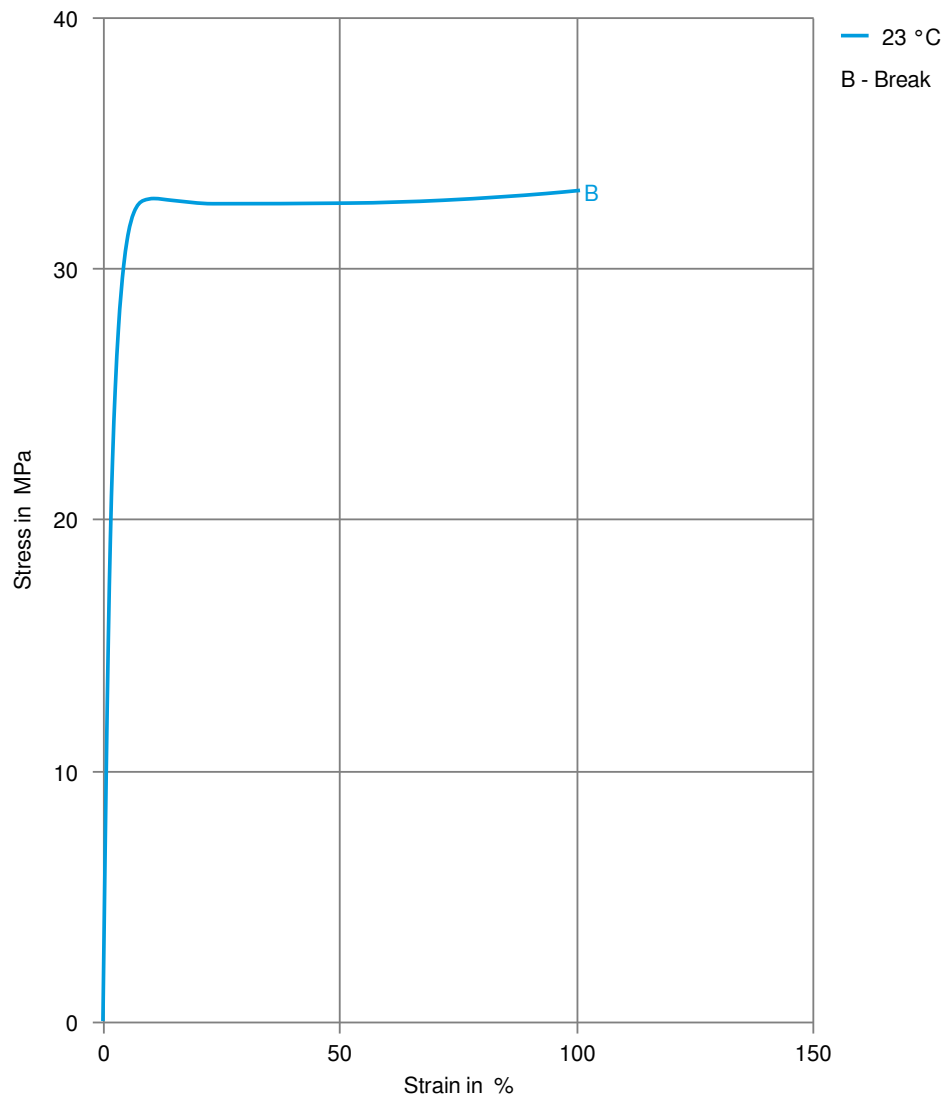
### Secant modulus-strain



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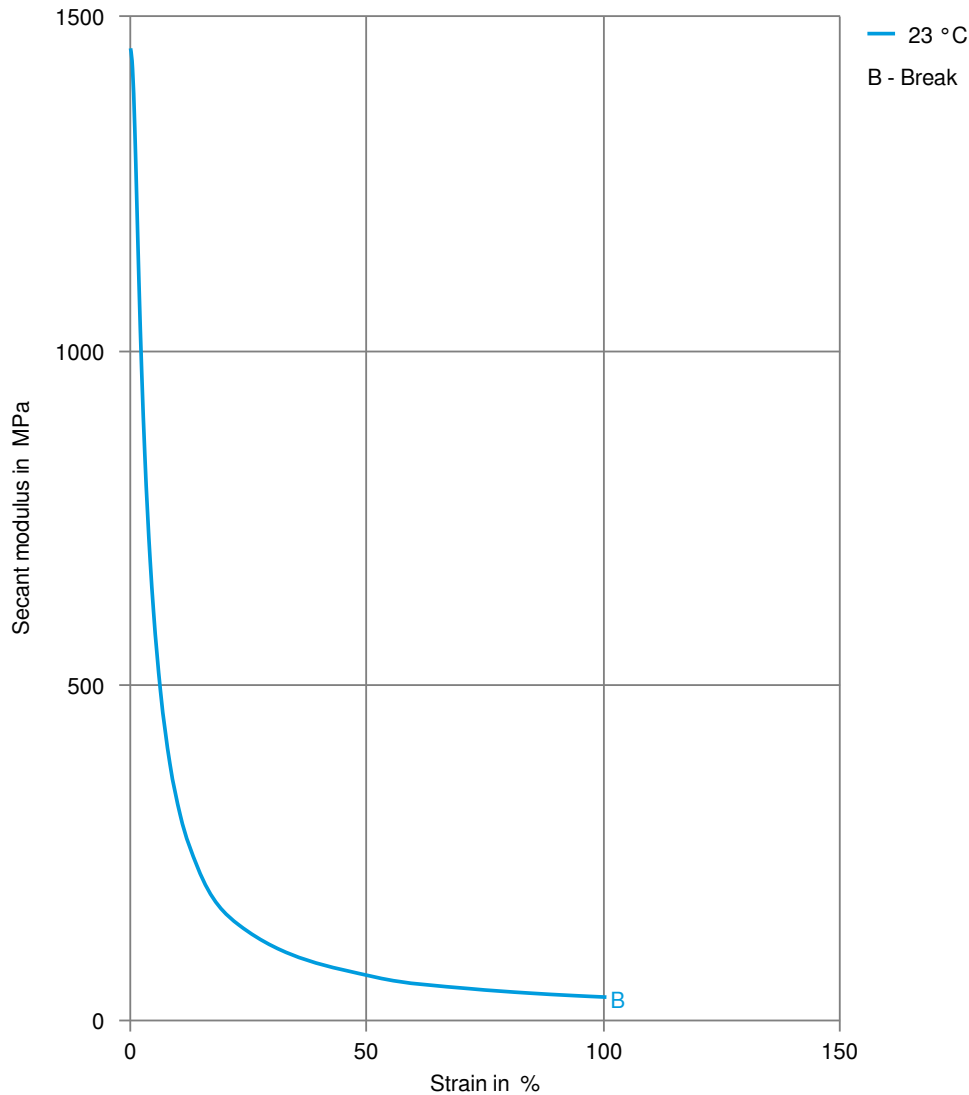
Stress-strain, 50mm/min



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Secant modulus-strain, 50mm/min



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