



Hostaform® C 2521 XAP²™

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

POM copolymer Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. 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 < 5 mg/kg (natural grades) Emission according to VDA 275 < 5 mg/kg (colored grades) Preliminary Datasheet

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Alkali Resistant • Chemical Resistant • Fuel Resistant	• High Impact Resistance • Hydrolysis Resistant • Low Emissions	• Solvent Resistant
Uses	• Automotive Applications	• Automotive Interior Parts	
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.50	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 73°F)	0.65	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	355000	psi	ISO 527-2/1A
Tensile Stress (Yield)	8990	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.3	ft·lb/in ²	
73°F	4.0	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	120	ft·lb/in ²	
73°F, Partial Break	120	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	331	°F	ISO 11357-3
CLTE - Flow	6.7E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.7E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Electric Strength	890	V/mil	IEC 60243-1

Hostaform® C 2521 XAP²™

Celanese Corporation - Acetal (POM) Copolymer

Electrical	Nominal Value	Unit	Test Method
Relative Permittivity			IEC 60250
100 Hz	4.00		
1 MHz	4.00		
Dissipation Factor			IEC 60250
100 Hz	1.5E-3		
1 MHz	5.0E-3		
Comparative Tracking Index	600	V	IEC 60112
Fill Analysis	Nominal Value	Unit	Test Method
Melt Density	1.20	g/cm ³	Internal Method
Melt Thermal Conductivity	1.1	Btu·in/hr/ft ² /°F	Internal Method
Ejection Temperature	284	°F	
Specific Heat Capacity of Melt	0.528	Btu/lb/°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 410	°F
Processing (Melt) Temp	374 to 410	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 580	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
 Zone4 temperature: 190 to 210°C
 Hot runner temperature: 190 to 210°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min