



Hostaform® S 27064 XAP²™

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

Polyacetal copolymer, impact modified

Easy flowing, elastomer-containing injection molding type based on HOSTAFORM C 27021 with high toughness and reduced emissions

HB. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for more than 1 mm thickness.

Emission according to VDA 275 < 10 mg/kg (natural and colored grades)

Ranges of applications: For thin-walled molded parts with high energy-absorbing capacity.

Preliminary datasheet

General

Material Status	• Commercial: Active
Availability	• Europe • North America
Additive	• Impact Modifier
Features	• Good Flow • Impact Modified • Good Toughness • Low Emissions
Uses	• Thin-walled Parts
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	19	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.7	%	
Flow	1.8	%	
Water Absorption (Saturation, 73°F)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	218000	psi	ISO 527-2/1A/1
Tensile Stress (Yield)	5950	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	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	2.9	ft·lb/in ²	
73°F	4.8	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	52	ft·lb/in ²	
73°F, Partial Break	71	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	171	°F	ISO 75-2/A

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Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	331	°F	ISO 11357-3
CLTE - Flow	7.2E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms·cm	IEC 60093
Electric Strength	710	V/mil	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.40		
1 MHz	4.40		
Dissipation Factor			IEC 60250
100 Hz	0.010		
1 MHz	0.020		
Comparative Tracking Index	600	V	IEC 60112

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 392	°F
Processing (Melt) Temp	374 to 392	°F
Mold Temperature	140 to 158	°F
Injection Pressure	8700 to 17400	psi
Injection Rate	Slow-Moderate	
Holding Pressure	8700 to 17400	psi
Back Pressure	0.00 to 290	psi

Injection Notes

Manifold Temperature: 190 to 200°C
Zone 4 Temperature: 190 to 200°C
Feed Temperature: 60 to 80°C

Notes

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

² 10°C/min