



Hostaform® S 27242 XAP²™

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

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 Preliminary data sheet

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• Good Flow	• Impact Modified	• Low Temperature Impact Resistance
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	17	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	312000	psi	ISO 527-2/1A
Tensile Stress (Yield)	7250	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	8.5	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	40	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.6	ft·lb/in ²	
73°F	3.1	ft·lb/in ²	
Charpy Unnotched Impact Strength (73°F)	62	ft·lb/in ²	ISO 179/1eU

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 176	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 290	psi

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Injection Notes

Feeding zone temperature: 60 to 80°C

Zone4 temperature: 190 to 200°C

Hot runner temperature: 190 to 200°C

Notes

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