Hostaform® S 9244 XAP² ™

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

POM copolymer, modified Injection molding type, elastomer-containing; with higher impact strength and slightly lower hardness, rigidity and chemical resistance than the basic type HOSTAFORM C 9021 Reduced emission grade, Emission according to VDA 275 < 5 mg/kg good weld strength. Preliminary Datasheet

General			
Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Impact Resistance	• Low Emissions	
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.40	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.6	%	
Flow	1.7	%	
Water Absorption (Saturation, 73°F)	1.2	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	210000	psi	ISO 527-2/1A
Tensile Stress (Yield)	4790	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Tensile Creep Modulus (1 hr)	174000	psi	ISO 899-1
Tensile Creep Modulus (1000 hr)	94300	psi	ISO 899-1
Flexural Modulus (73°F)	210000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	5.7	ft·lb/in²	
73°F	8.6	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F, Partial Break	95	ft·lb/in²	
73°F	No Break		
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	154	°F	ISO 75-2/A
Vicat Softening Temperature	239	°F	ISO 306/B50
Melting Temperature [2]	331	°F	ISO 11357-3
CLTE - Flow	7.2E-5	in/in/°F	ISO 11359-2

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Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms·cm	IEC 60093
Relative Permittivity			IEC 60250
100 Hz	3.60		
1 MHz	3.60		
Dissipation Factor			IEC 60250
100 Hz	4.0E-3		
1 MHz	6.0E-3		
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 176	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C

Zone4 temperature: 190 to 200°C

Notes

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

[2] 10°C/min