HOSTAFORM® C 9021 XAP®2 - POM

Description

POM copolymer Standard injection molding grade 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 < 2 mg/kg (natural grades) Emission according to VDA 275 < 5 mg/kg (colored grades)

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m³	ISO 1183
Melt volume rate, MVR	8	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.65	%	ISO 62
Humidity absorption, 23°C/50%RH	0.2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2700	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	64	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	10	%	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	35	%	ISO 527-2/1A
Tensile creep modulus, 1h	2400	MPa	ISO 899-1
Tensile creep modulus, 1000h	1200	MPa	ISO 899-1
Flexural modulus, 23°C	2600	MPa	ISO 178
Charpy impact strength, 23°C	220 ^[P]	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	220	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	6.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	6	kJ/m²	ISO 179/1eA
P: Partial Break			

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	104	°C	ISO 75-1, -2
DTUL at 0.45 MPa	157	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	150	°C	ISO 306
Coeff. of linear therm expansion, parallel	1.2	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1.2	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Dielectric constant (Dk), 100Hz	4	-	IEC 60250
Dielectric constant (Dk), 1MHz	4	-	IEC 60250
Dissipation factor, 100Hz	20	E-4	IEC 60250
Dissipation factor, 1MHz	50	E-4	IEC 60250
Volume resistivity	1E12	Ohm*m	IEC 60093
Surface resistivity	1E14	Ohm	IEC 60093
Electric strength	35	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-

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Zone1 temperature	170 - 175	°C	-
Zone2 temperature	180 - 185	°C	-
Zone3 temperature	180 - 195	°C	-
Zone4 temperature	180 - 200	°C	-
Nozzle temperature	190 - 200	°C	-
Melt temperature	180 - 200	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow-medium	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	150	RPM	-
Screw speed diameter, 40mm	100	RPM	-
Screw speed diameter, 55mm	70	RPM	-

Other text information

Pre-drying

recommended

Injection molding

Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Melt temperature 180-190 °C Mould temperature 60-120 °C

Characteristics

Product Categories	Delivery Form
Unfilled	Pellets
Processing	Additives
Injection molding	Release agent
Injection molaina	Release agent

Contact Information

Americas	Asia	Europe	
8040 Dixie Highway	4560 Jinke Road	Am Unisys-Park 1	
Florence, KY 41042 USA	Zhang Jiang Hi Tech Park	65843 Sulzbach, Germany	
Product Information Service	Shanghai 201203 PRC	Product Information Service	
t: +1-800-833-4882	Customer Service	t: +49-800-86427-531	
t: +1-859-372-3244	t: +86 21 3861 9266	t: +49-(0)-69-45009-1011	
Customer Service	f: +86 21 3861 9599	e: info-engineeredmaterials-eu@celanese.com	
t: +1-800-526-4960	e: info-engineeredmaterials-asia@celanese.com		
t: +1-859-372-3214			

e: info-engineeredmaterials-am@celanese.com

General Disclaimer

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