HOSTAFORM® S 9243 XAP®2 - POM

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. Burning rate according to FMVSS 302 < 100 mm/min (1 mm thickness) Preliminary Datasheet

Physical properties	Value	Unit	Test Standard
Density	**1330**	kg/m³	ISO 1183
Melt volume rate, MVR	**4**	cm³/10min	ISO 1133
MVR temperature	**190**	°C	ISO 1133
MVR load	**2.16**	kg	ISO 1133
Molding shrinkage, parallel	**1.9**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.8**	%	ISO 294-4, 2577
Water absorption, 23°C-sat	**1**	%	ISO 62
Humidity absorption, 23°C/50%RH	**0.2**	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**1950**	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	**44**	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	**9**	%	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	**40**	%	ISO 527-2/1A
Tensile creep modulus, 1h	**1700**	MPa	ISO 899-1
Tensile creep modulus, 1000h	**950**	MPa	ISO 899-1
Flexural modulus, 23°C	**1850**	MPa	ISO 178
Charpy impact strength, 23°C	**NB**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**200**[P]	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	**15**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**9**	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	**75**	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	**130**	°C	ISO 306
Coeff. of linear therm expansion, parallel	**1.2**	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Dielectric constant (Dk), 100Hz	**3.8**	-	IEC 60250
Dielectric constant (Dk), 1MHz	**3.8**	-	IEC 60250
Dissipation factor, 100Hz	**30**	E-4	IEC 60250
Dissipation factor, 1MHz	**60**	E-4	IEC 60250
Volume resistivity	**1E11**	Ohm*m	IEC 60093
Surface resistivity	**1E13**	Ohm	IEC 60093
Comparative tracking index	**600**	-	IEC 60112

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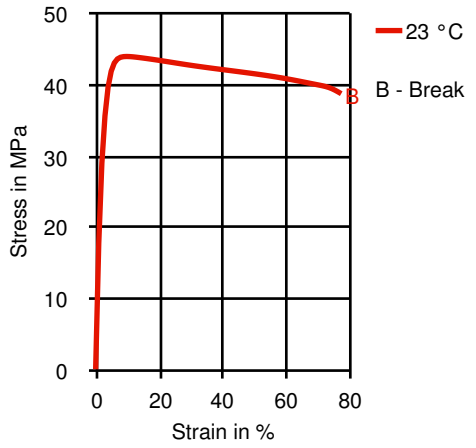
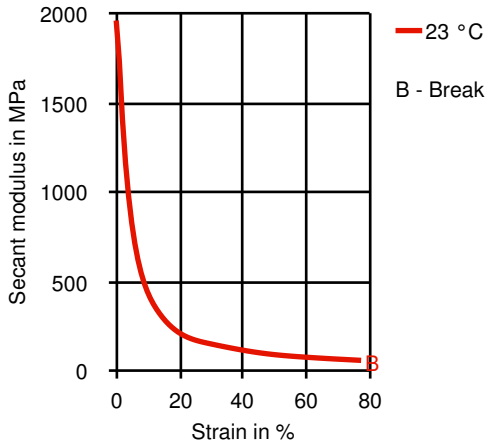
Diagrams

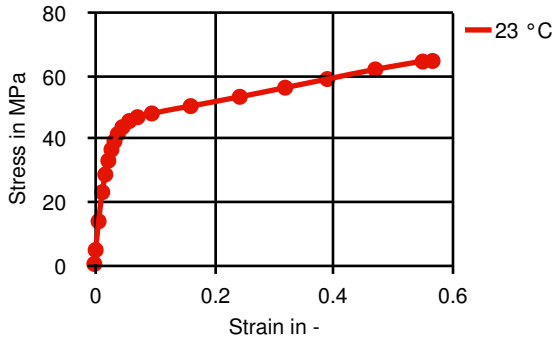
Stress-strain



Secant modulus-strain



True Stress-strain



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	-
Zone1 temperature	**170 - 180**	°C	-
Zone2 temperature	**180 - 190**	°C	-
Zone3 temperature	**190 - 200**	°C	-
Zone4 temperature	**190 - 200**	°C	-
Nozzle temperature	**190 - 200**	°C	-
Melt temperature	**190 - 200**	°C	-
Mold temperature	**60 - 80**	°C	-
Hot runner temperature	**190 - 200**	°C	-
Pressure	**Value**	**Unit**	**Test Standard**
Back pressure max.	**20**	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	-

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Other text information

Pre-drying

It is normally not necessary to dry HOSTAFORM. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required. A circulating air drying cabinet can be used for this purpose if the granul

Longer pre-drying times/storage

The product can then be stored in standard conditions until processed.

Characteristics

Product Categories	Delivery Form
Impact modified	Pellets
Processing	**Additives**
Injection molding	Release agent

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