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**HOSTAFORM® C 27021 XAP<sup>2</sup>™ LS colored | POM | UV Resistant**


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**Description**


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Polyacetalcopolymer

Easy flow injection molding grade with reduced emissions especially for automotive interior application.  
With Improved UV resistance

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

Emission according to VDA 275 < 5 mg/kg

Preliminary Datasheet

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1410</b>	kg/m <sup>3</sup>	ISO 1183
Melt volume rate (MVR)	<b>24</b>	cm <sup>3</sup> /10min	ISO 1133
MVR test temperature	<b>190</b>	°C	ISO 1133
MVR test load	<b>2.16</b>	kg	ISO 1133
Water absorption (23°C-sat)	<b>0.65</b>	%	ISO 62

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile modulus (1mm/min)	<b>2750</b>	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	<b>64</b>	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	<b>7.5</b>	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	<b>17</b>	%	ISO 527-2/1A
Tensile creep modulus (1h)	<b>2400</b>	MPa	ISO 899-1
Tensile creep modulus (1000h)	<b>1200</b>	MPa	ISO 899-1
Flexural modulus (23°C)	<b>2600</b>	MPa	ISO 178
Charpy impact strength @ 23°C	<b>170.0</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength @ -30°C	<b>170.0</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>5.5</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength @ -30°C	<b>5.5</b>	kJ/m <sup>2</sup>	ISO 179/1eA

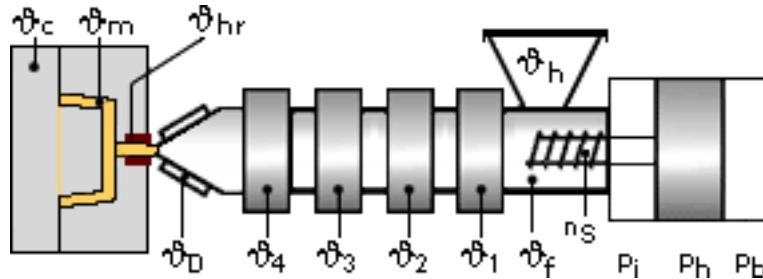
<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Melting temperature (10°C/min)	<b>164</b>	°C	ISO 11357-1,-2,-3
Coeff.of linear therm. expansion (parallel)	<b>1.1</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>1.1</b>	E-4/°C	ISO 11359-2

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Relative permittivity - 100 Hz	<b>4</b>	-	IEC 60250
Relative permittivity - 1 MHz	<b>4</b>	-	IEC 60250
Dissipation factor - 100 Hz	<b>20</b>	E-4	IEC 60250
Dissipation factor - 1 MHz	<b>50</b>	E-4	IEC 60250
Volume resistivity	<b>1E12</b>	Ohm*m	IEC 60093
Surface resistivity	<b>1E14</b>	Ohm	IEC 60093
Electric strength	<b>35</b>	kV/mm	IEC 60243-1
Comparative tracking index CTI	<b>600</b>	-	IEC 60112

<b>Test specimen production</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988-2	-	Internal

**Typical injection moulding processing conditions**

**Pre Drying:**

**Necessary low maximum residual moisture content: 0.15%**  
recommended

**Drying time: 3-4 h**

**Drying temperature: 120 - 140 °C**

**Temperature:**

	ϕManifold	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1	ϕFeed	ϕHopper
min (°C)	190	80	180	190	180	180	180	170	60	20
max (°C)	200	120	200	200	200	195	185	175	80	30

**Pressure:**

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	40

Above pressures, including back pressure, are given as specific or plastic pressures. The back pressure on Hostaform® and Celcon® POM materials should be as low as possible, just enough to remove air from the pellets during feeding.

**Speed:**

**Injection speed: slow-medium**

**Screw speed**

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	150	100	70	-

**Injection Molding**

Standard injection moulding machines with three phase (15 to 25 D)

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plasticating screws will fit.

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

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**Contact Information**

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Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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