

## HOSTAFORM® C 2521 XAP<sup>2</sup>™ | POM | Unfilled

### Description

POM copolymer  
Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. 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 < 5 mg/kg (natural grades)

Emission according to VDA 275 < 5 mg/kg (colored grades)

Preliminary Datasheet

Physical properties	Value	Unit	Test Standard
Density	<b>1410</b>	kg/m <sup>3</sup>	ISO 1183
Melt volume rate (MVR)	<b>2.5</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

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>2450</b>	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	<b>62</b>	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	<b>9</b>	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	<b>35</b>	%	ISO 527-2/1A
Charpy impact strength @ 23°C	<b>220P</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength @ -30°C	<b>200</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>8.5</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength @ -30°C	<b>7.0</b>	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	<b>166</b>	°C	ISO 11357-1,-2,-3
Coeff.of linear therm. expansion (parallel)	<b>1.2</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>1.2</b>	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	<b>4</b>	-	IEC 60250
Relative permittivity - 1 MHz	<b>4</b>	-	IEC 60250
Dissipation factor - 100 Hz	<b>15</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

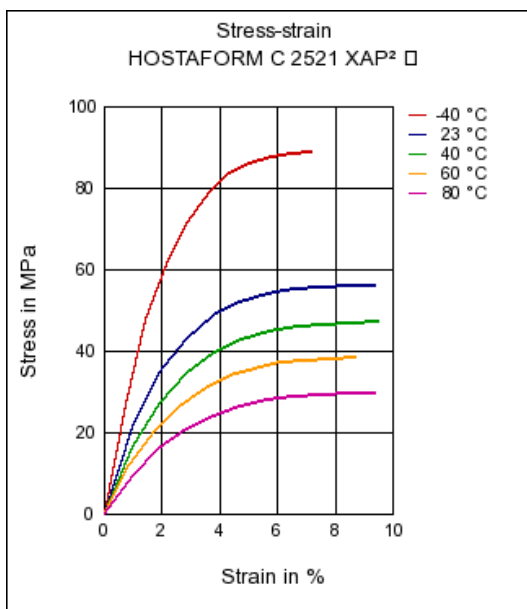
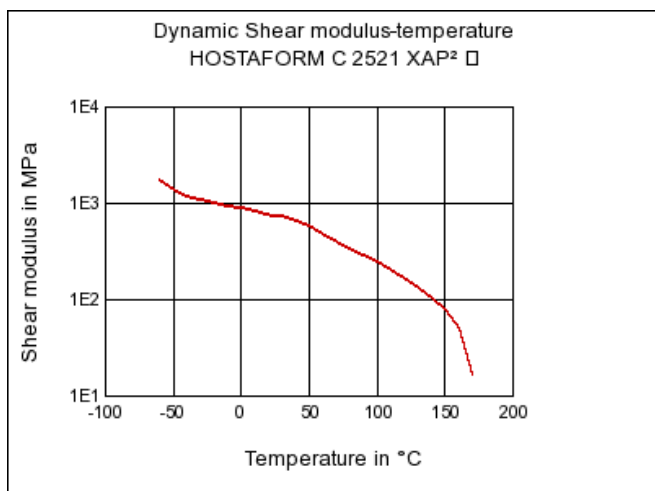
Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	<b>9988</b>	-	Internal

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Rheological Calculation properties	Value	Unit	Test Standard
Density of melt	<b>1200</b>	kg/m <sup>3</sup>	Internal
Thermal conductivity of melt	<b>0.155</b>	W/(m K)	Internal
Specific heat capacity of melt	<b>2210</b>	J/(kg K)	Internal
Ejection temperature	<b>165</b>	°C	Internal

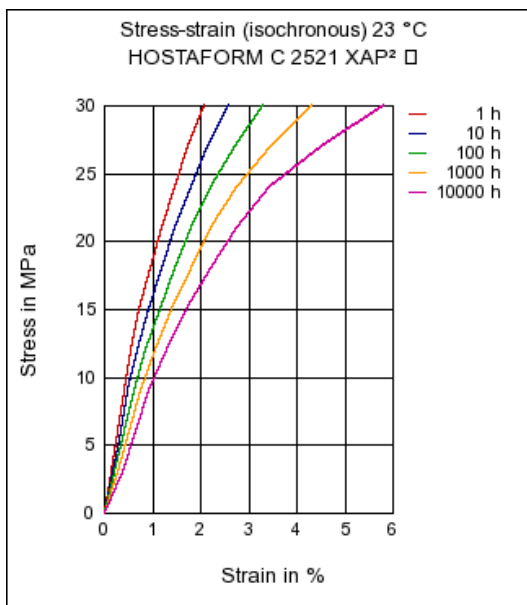
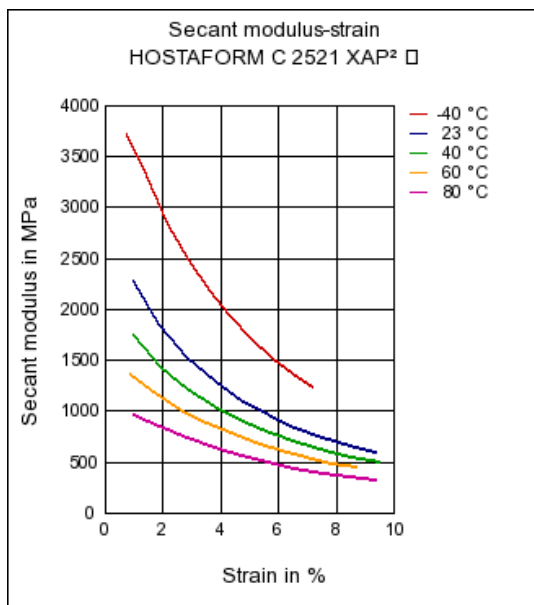
**Dynamic Shear modulus-temperature**

**Stress-strain**



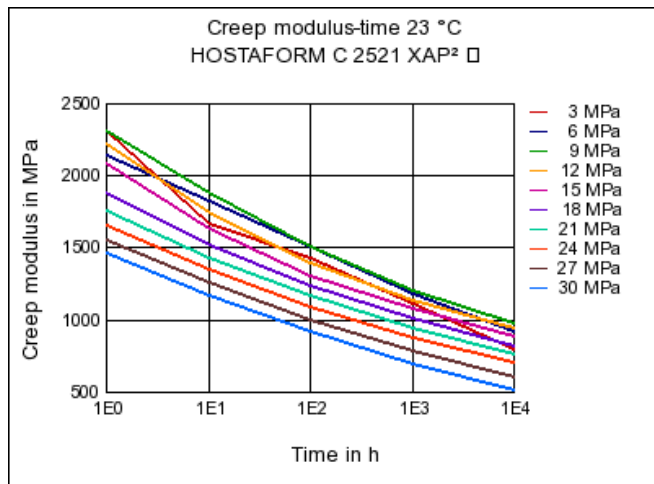
**Secant modulus-strain**

**Stress-strain (isochronous)**

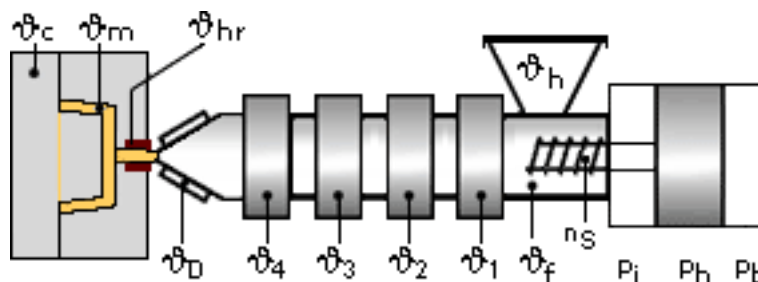


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**Creep modulus-time**



**Typical injection moulding processing conditions**



**Pre Drying:**

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

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 granules

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

**Drying time: 3 - 4 h**

**Drying temperature: 120 - 140 °C**

**Temperature:**

	ϕ Manifold	ϕ Mold	ϕ Melt	ϕ Nozzle	ϕ Zone4	ϕ Zone3	ϕ Zone2	ϕ Zone1	ϕ Feed	ϕ Hopper
min (°C)	190	80	190	190	190	190	180	170	60	20
max (°C)	210	120	210	210	210	200	190	180	80	30

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### Pressure:

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

### Speed:

**Injection speed: slow-medium**

### Screw speed

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

## Contact Information

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## General Disclaimer

**NOTICE TO USERS:** Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

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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