

HOSTAFORM® S 27064 XAP²™ | POM | Impact Modified

Description

Polyacetal copolymer, impact modified

Easy flowing, elastomer-containing injection molding type based on HOSTAFORM C 27021 with high toughness and reduced emissions

HB. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for more than 1 mm thickness.

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

Ranges of applications: For thin-walled molded parts with high energy-absorbing capacity.

Preliminary datasheet

Physical properties	Value	Unit	Test Standard
Density	1370	kg/m ³	ISO 1183
Melt volume rate (MVR)	18	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	1.8	%	ISO 294-4
Mold shrinkage - normal	1.7	%	ISO 294-4
Water absorption (23°C-sat)	0.65	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	1700	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	44	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	10	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	35	%	ISO 527-2/1A
Tensile creep modulus (1h)	1400	MPa	ISO 899-1
Tensile creep modulus (1000h)	800	MPa	ISO 899-1
Flexural modulus (23°C)	1700	MPa	ISO 178
Charpy impact strength @ 23°C	150P	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	110	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	11	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	6	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	166	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	77	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	1.3	E-4/°C	ISO 11359-2

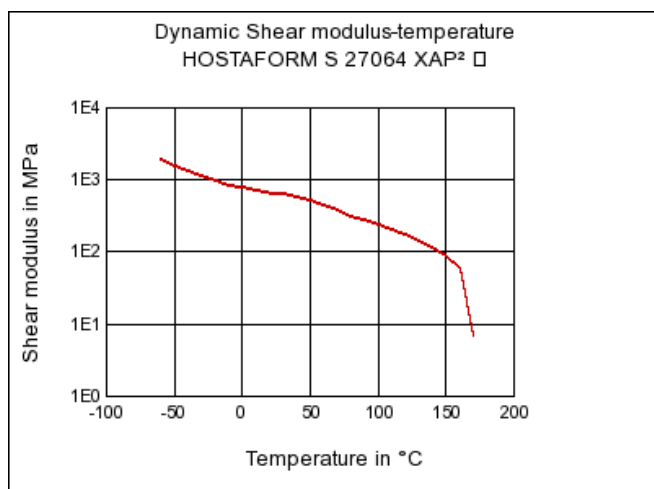
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4.4	-	IEC 60250
Relative permittivity - 1 MHz	4.4	-	IEC 60250
Dissipation factor - 100 Hz	100	E-4	IEC 60250
Dissipation factor - 1 MHz	200	E-4	IEC 60250
Volume resistivity	1E11	Ohm*m	IEC 60093
Surface resistivity	1E13	Ohm	IEC 60093
Electric strength	28	kV/mm	IEC 60243-1

HOSTAFORM® S 27064 XAP²™ | POM | Impact Modified

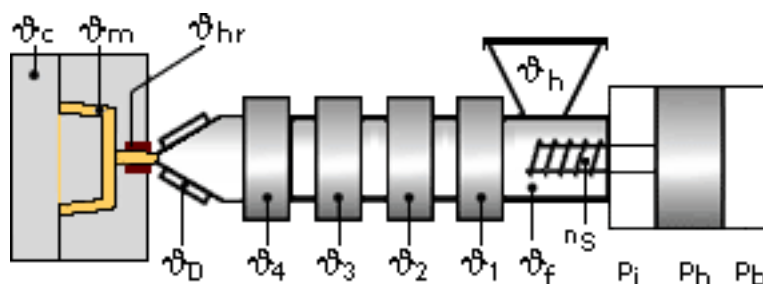
Electrical properties	Value	Unit	Test Standard
Comparative tracking index CTI	600	-	IEC 60112

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988	-	Internal

Dynamic Shear modulus-temperature



Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.15%

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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

Drying time: 3 - 4 h

Drying temperature: 100 - 120 °C

HOSTAFORM® S 27064 XAP²™ | POM | Impact Modified

Temperature:

	ϑ _{Manifold}	ϑ _{Mold}	ϑ _{Melt}	ϑ _{Nozzle}	ϑ _{Zone4}	ϑ _{Zone3}	ϑ _{Zone2}	ϑ _{Zone1}	ϑ _{Feed}	ϑ _{Hopper}
min (°C)	190	60	190	190	190	190	180	170	60	20
max (°C)	200	70	200	200	200	200	190	180	80	30

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	20

Speed:

Injection speed: slow-medium

Screw speed

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

Contact Information

Americas

Ticona North American Headquarters
Product Information Service
8040 Dixie Highway
Florence, KY 41042
USA
Tel.: +1-800-833-4882
Tel.: +1-859-372-3244
email: prodinfo@ticona.com
Ticona on the web: www.ticona.com

Customer Service

Tel.: +1-800-526-4960
Tel.: +1-859-372-3214
Fax: +1-859-372-3125

Europe

Ticona GmbH
Information Service
Tel.: +49 (0) 180-5842662 (Germany)
+49 (0) 69-30516299 (Europe)
Fax: +49 (0) 180-2021202 (Germany & Europe)
email: infoservice@ticona.de
Internet: www.ticona.com

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.

To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication.

Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards.

HOSTAFORM® S 27064 XAP²™ | POM | Impact Modified

We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

The products mentioned herein are not intended for use in medical or dental implants.

© Copyright 2007, Ticona, all rights reserved. (Pub. 26-September-2013)