

HOSTAFORM® S 27242 XAP²™ | POM | Impact Modified

Description

Easy flow, impact modified injection molding grade, with good low temperature impact strength and good weld line strength and reduced emissions. Emission according to VDA 275 < 5 mg/kg

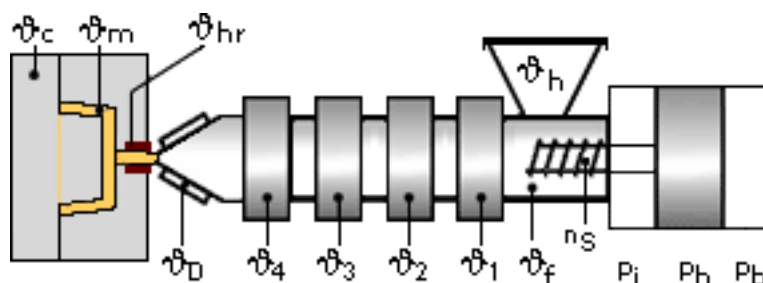
Preliminary data sheet

Physical properties	Value	Unit	Test Standard
Density	1350	kg/m ³	ISO 1183
Melt volume rate (MVR)	16	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2200	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	50	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	8.5	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	40	%	ISO 527-2/1A
Charpy impact strength @ 23°C	130.0	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	7.0	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	6.0	kJ/m ²	ISO 179/1eA

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%

Drying time: 3-4 h

Drying temperature: 100 - 120 °C

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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	80	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	-

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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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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.

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