

HOSTAFORM® S 9243 XAP²™ | POM | Impact Modified

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/m ³	ISO 1183
Melt volume rate (MVR)	4	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	1.9	%	ISO 294-4
Mold shrinkage - normal	1.8	%	ISO 294-4
Water absorption (23°C-sat)	1	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	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
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/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	200P	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	15.0	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	9.0	kJ/m ²	ISO 179/1eA

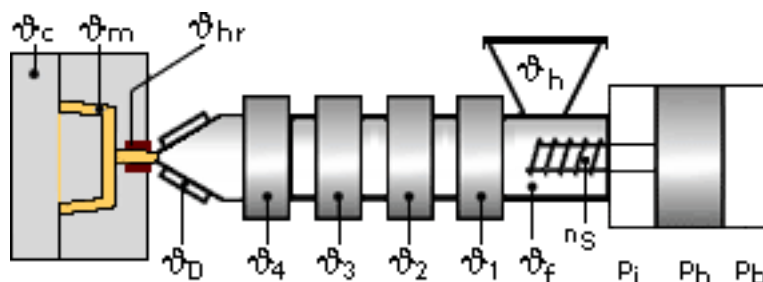
Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	166	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	75	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	1.2	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	3.8	-	IEC 60250
Relative permittivity - 1 MHz	3.8	-	IEC 60250
Dissipation factor - 100 Hz	30	E-4	IEC 60250
Dissipation factor - 1 MHz	60	E-4	IEC 60250
Volume resistivity	1E11	Ohm*m	IEC 60093
Surface resistivity	1E13	Ohm	IEC 60093
Comparative tracking index CTI	600	-	IEC 60112

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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%

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

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

Drying time: 3 - 4 h

Drying temperature: 100 - 120 °C

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
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

	16	25	40	55	75
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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