

HOSTAFORM® C 2521 XAP®2

low Emission

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).

Rheological properties

Melt volume-flow rate	2.5 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	

Typical mechanical properties

Tensile Modulus	2450 MPa	ISO 527-1/-2
Yield stress, 50mm/min	62 MPa	ISO 527-1/-2
Yield strain, 50mm/min	9 %	ISO 527-1/-2
Nominal strain at break	35 %	ISO 527-1/-2
Charpy impact strength, 23°C	250 ^[P] kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	250 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7 kJ/m ²	ISO 179/1eA

[P]: Partial Break

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	101 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	151 °C	ISO 306
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.155 W/(m K)	Internal
Spec. heat capacity of melt	2210 J/(kg K)	Internal

Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	4	IEC 62631-2-1
Dissipation factor, 100Hz	15 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	50 E-4	IEC 62631-2-1
Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	35 kV/mm	IEC 60243-1
Comparative tracking index	PLC 0 PLC	UL 746A



HOSTAFORM® C 2521 XAP®2

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.65 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183
Density of melt	1200 kg/m ³	Internal

Injection

Drying Temperature	100 - 120 °C	
Drying Time, Dehumidified Dryer	3 - 4 h	
Processing Moisture Content	0.15 %	
Screw tangential speed	0.2 - 0.21 m/s	
Max. mould temperature	80 - 120 °C	
Back pressure	4 MPa	
Injection speed	slow-medium	
Ejection temperature	140 °C	Internal

Characteristics

Additives	Release agent
-----------	---------------

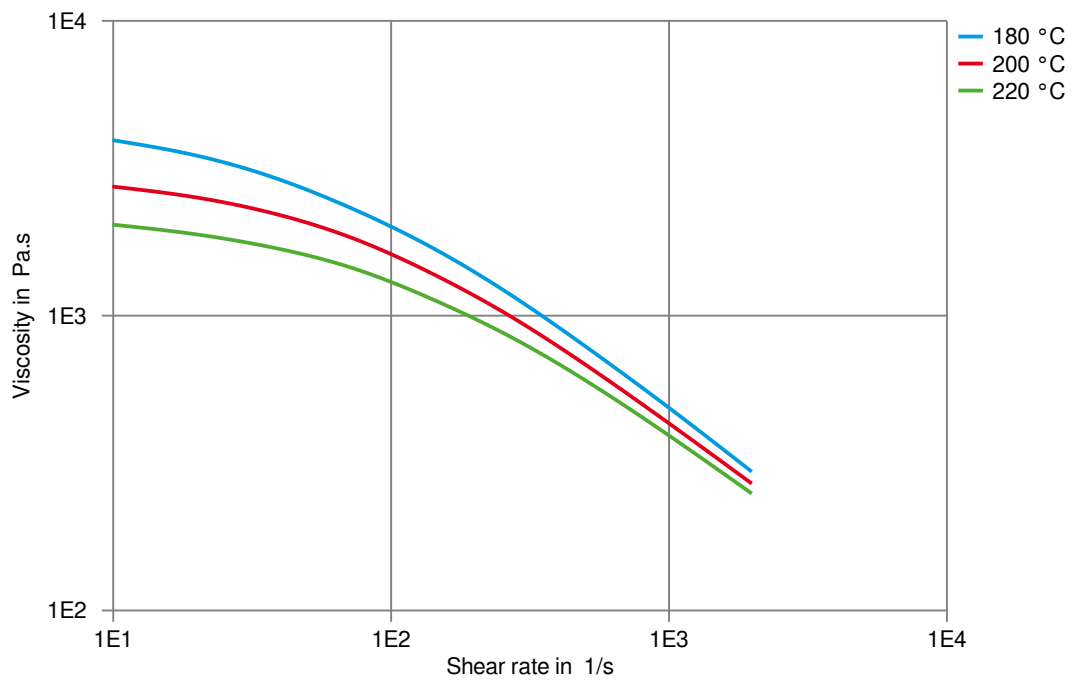
Additional information

Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
-------------------	--



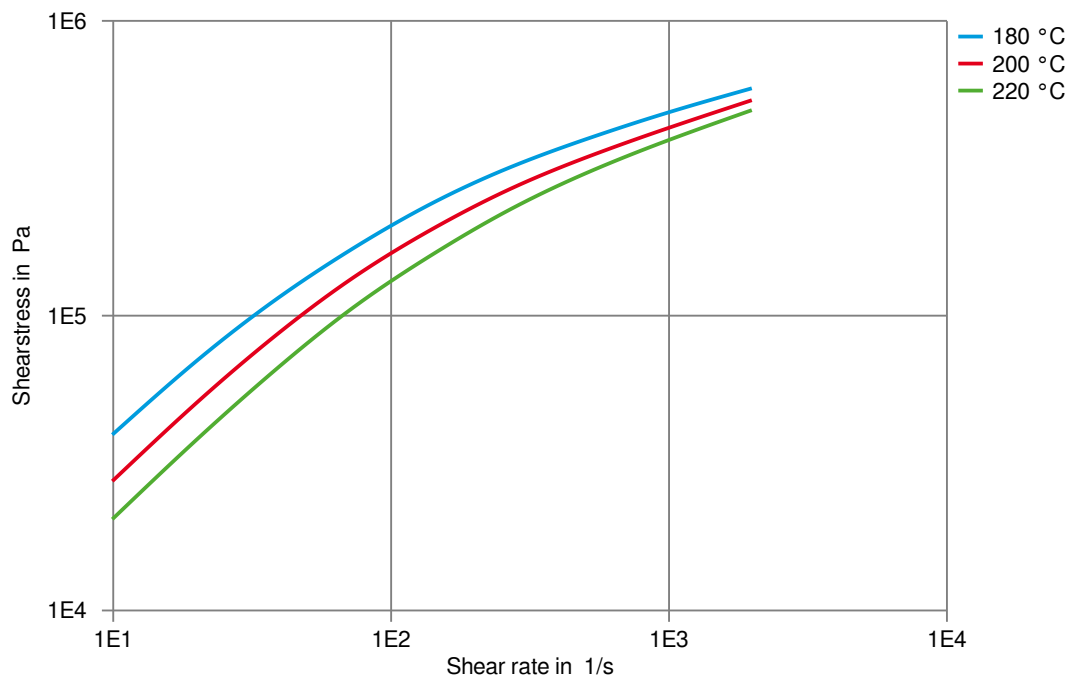
HOSTAFORM® C 2521 XAP®2

Viscosity-shear rate



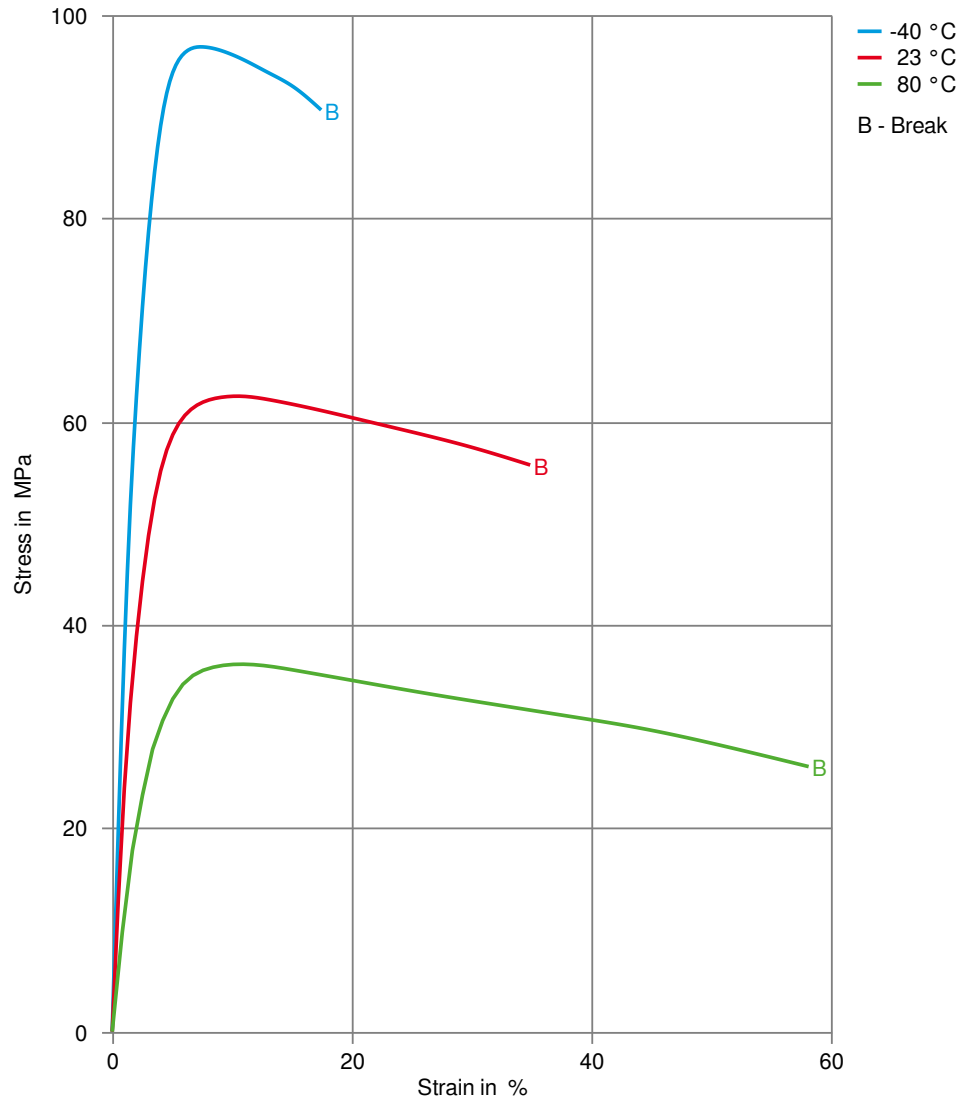
HOSTAFORM® C 2521 XAP®2

Shearstress-shear rate



HOSTAFORM® C 2521 XAP®2

Stress-strain

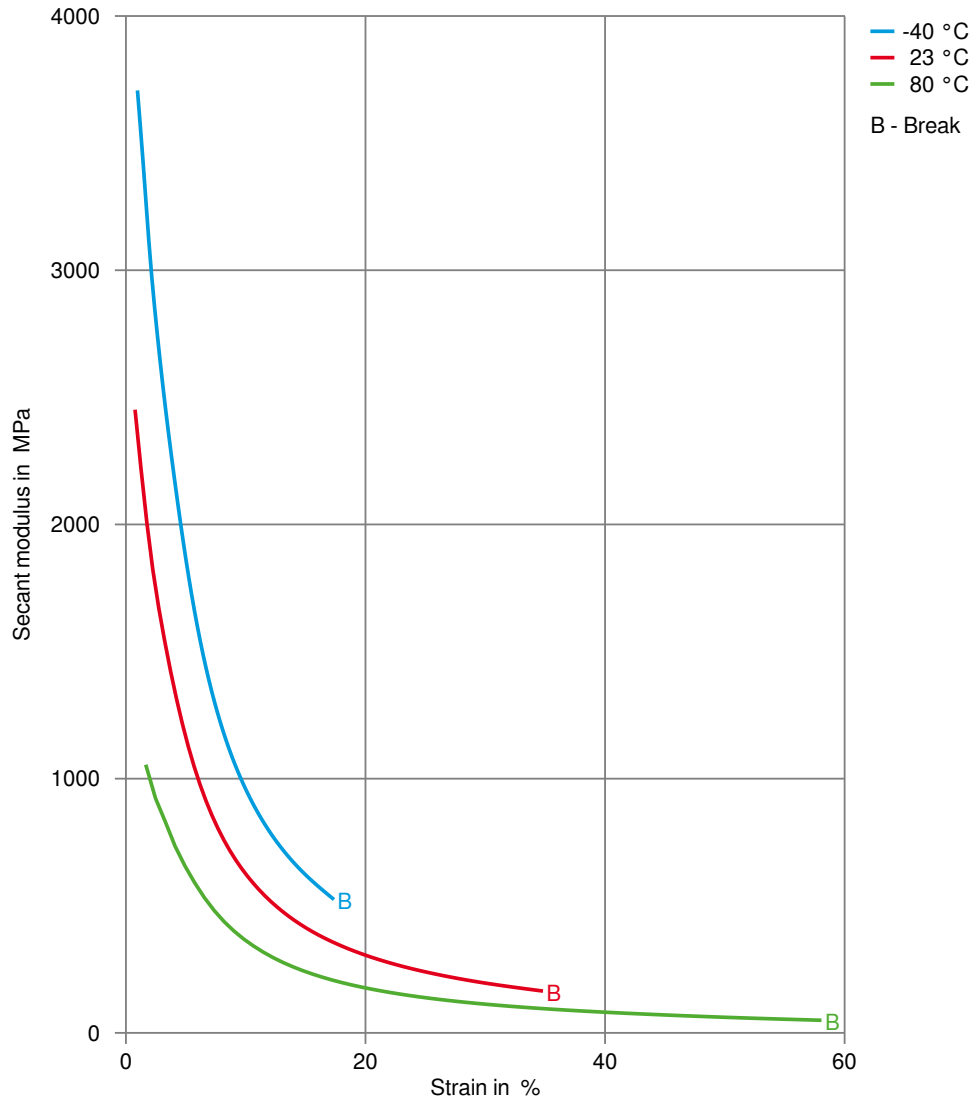


Printed: 2023-09-15



HOSTAFORM® C 2521 XAP®2

Secant modulus-strain

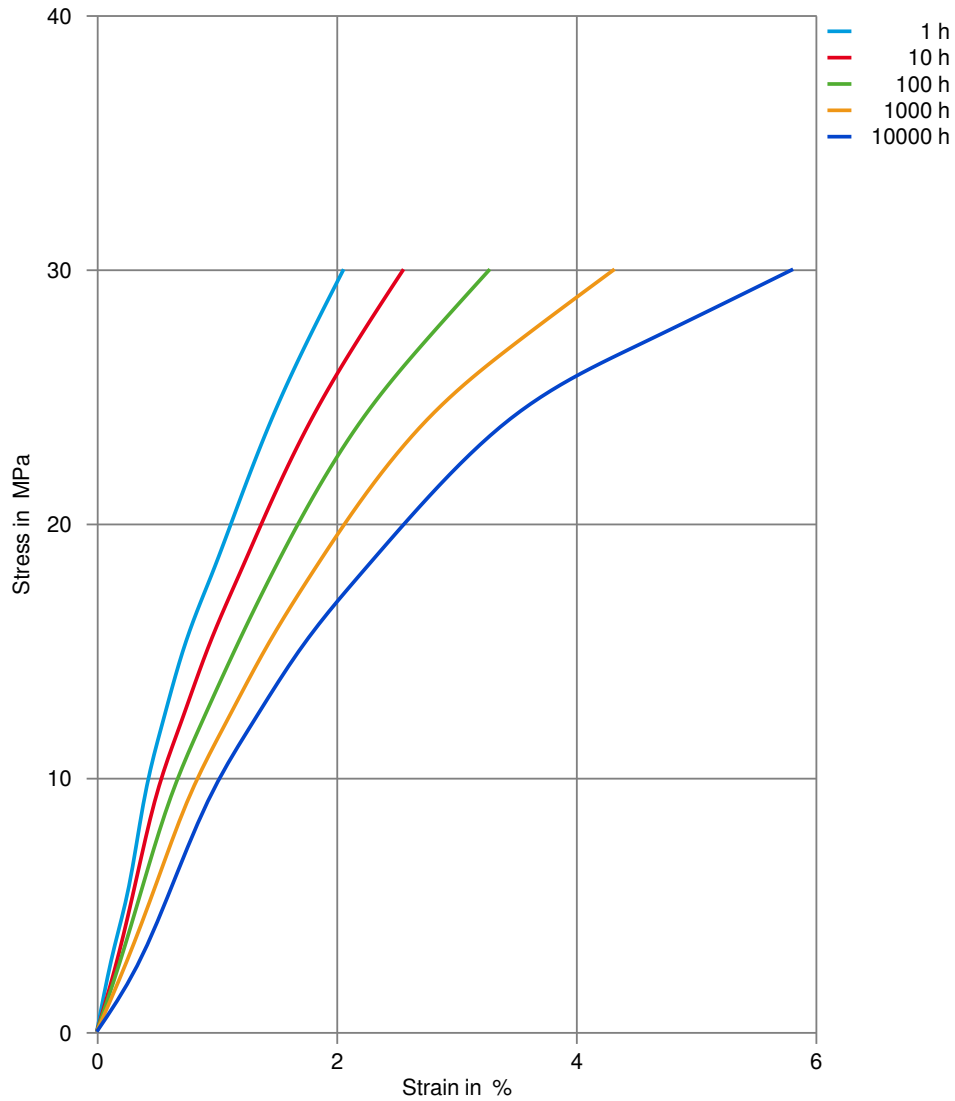


Printed: 2023-09-15



HOSTAFORM® C 2521 XAP®2

Stress-strain (isochronous) 23°C

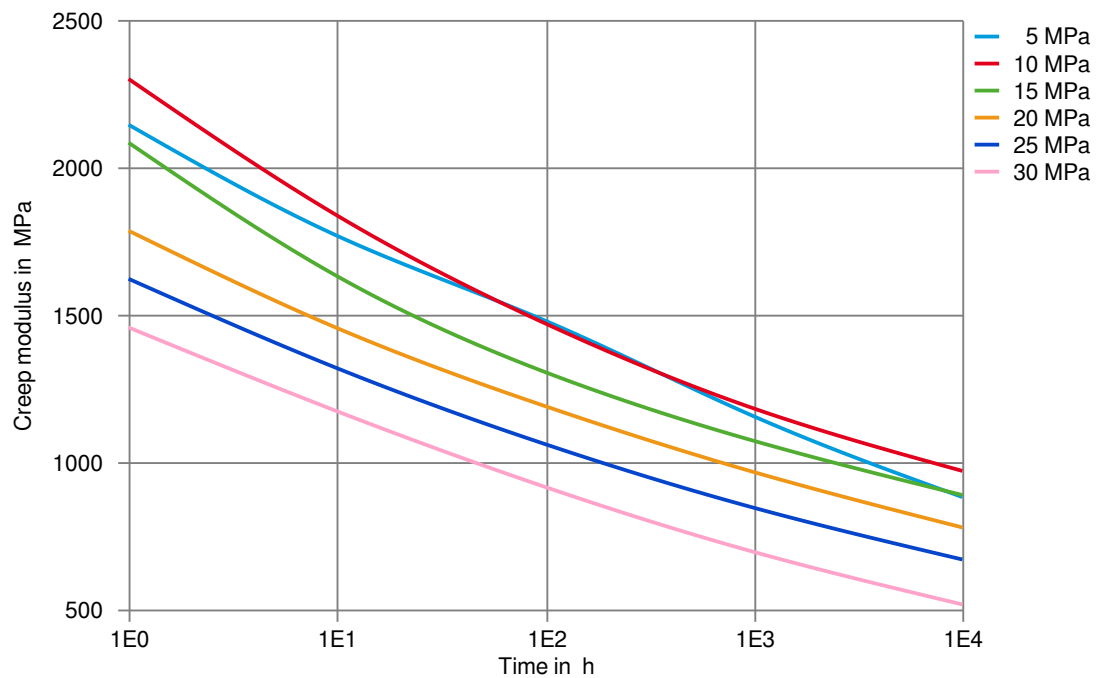


Printed: 2023-09-15



HOSTAFORM® C 2521 XAP®2

Creep modulus-time 23°C

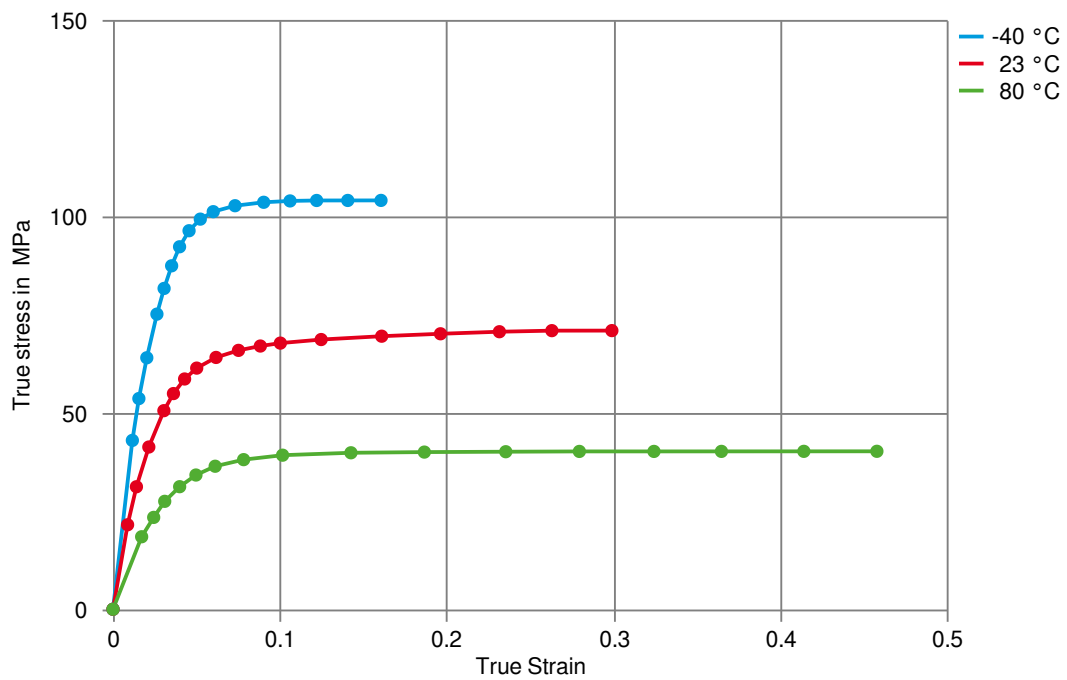


Printed: 2023-09-15



HOSTAFORM® C 2521 XAP®2

True stress-strain



HOSTAFORM® C 2521 XAP®2

Processing Texts

Pre-drying	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
Longer pre-drying times/storage	The product can then be stored in standard conditions until processed.
Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
Injection molding Preprocessing	To achieve low emission values pre drying using a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended. Max. Water content 0,1 %
Injection molding Postprocessing	Conditioning e.g. moisturizing is not necessary.

Other Approvals

Other Approvals	OEM	Specification	Additional Information
	Mercedes-Benz Group (Daimler)	DBL 5404	BQF
	Mercedes-Benz Group (Daimler)	DBL 5410	
	Ford	WSK-M4D635-A1	
	Li Auto	Q/LiA5310020	2021 (V2)
	Renault		No spec listed
	VW Group	TL 524 76	Natural

Printed: 2023-09-15

