

HOSTAFORM® S 27064 XAP®

Impact modified, low emission

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 < 10 mg/kg (natural and colored grades) Ranges of applications: For thin-walled molded parts with high energy-absorbing capacity. Preliminary datasheet

Rheological properties

Melt volume-flow rate	19 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage range, parallel	1.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.7 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	1500 MPa	ISO 527-1/-2
Yield stress, 50mm/min	41 MPa	ISO 527-1/-2
Yield strain, 50mm/min	10 %	ISO 527-1/-2
Nominal strain at break	35 %	ISO 527-1/-2
Charpy impact strength, 23°C	150 ^[P] kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	110 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	6 kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 358/30	90 MPa	ISO 2039-1

[P]: Partial Break

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	77 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	125 °C	ISO 306
Coeff. of linear therm. expansion, parallel	130 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	4.4	IEC 62631-2-1
Relative permittivity, 1MHz	4.4	IEC 62631-2-1
Dissipation factor, 100Hz	100 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200 E-4	IEC 62631-2-1
Volume resistivity	1E11 Ohm.m	IEC 62631-3-1
Surface resistivity	1E13 Ohm	IEC 62631-3-2
Electric strength	28 kV/mm	IEC 60243-1
Comparative tracking index	PLC 0 PLC	UL 746A



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Other properties

Humidity absorption, 2mm	0.25 %	Sim. to ISO 62
Water absorption, 2mm	0.65 %	Sim. to ISO 62
Density	1370 kg/m ³	ISO 1183

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	60 - 70 °C
Back pressure	2 MPa
Injection speed	slow-medium

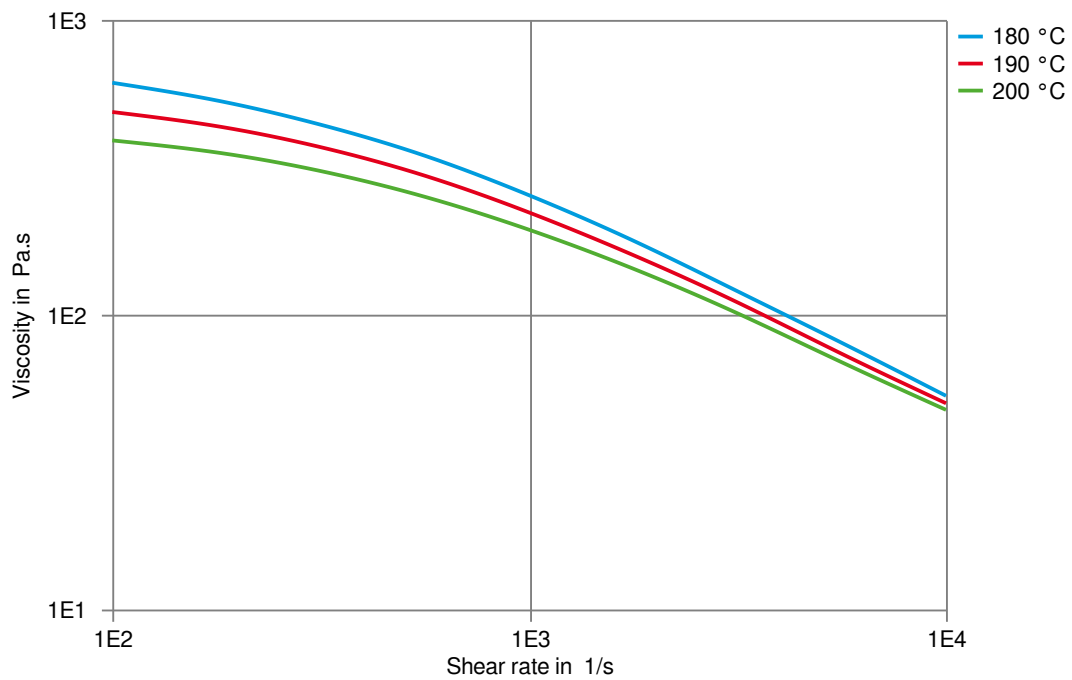
Characteristics

Additives	Release agent
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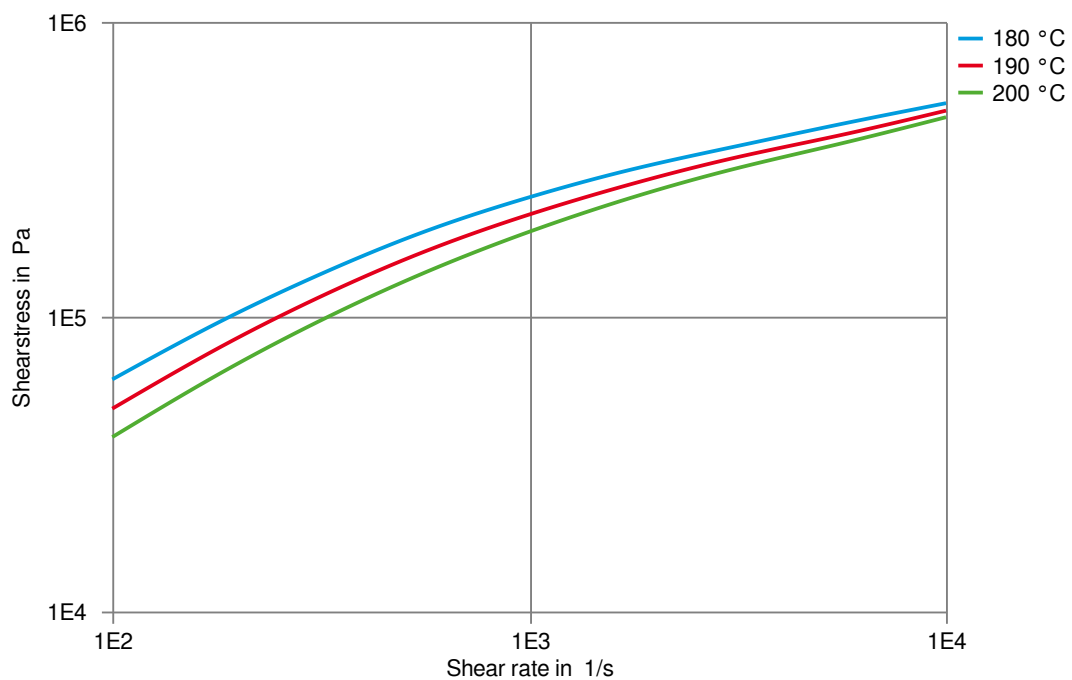
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Viscosity-shear rate



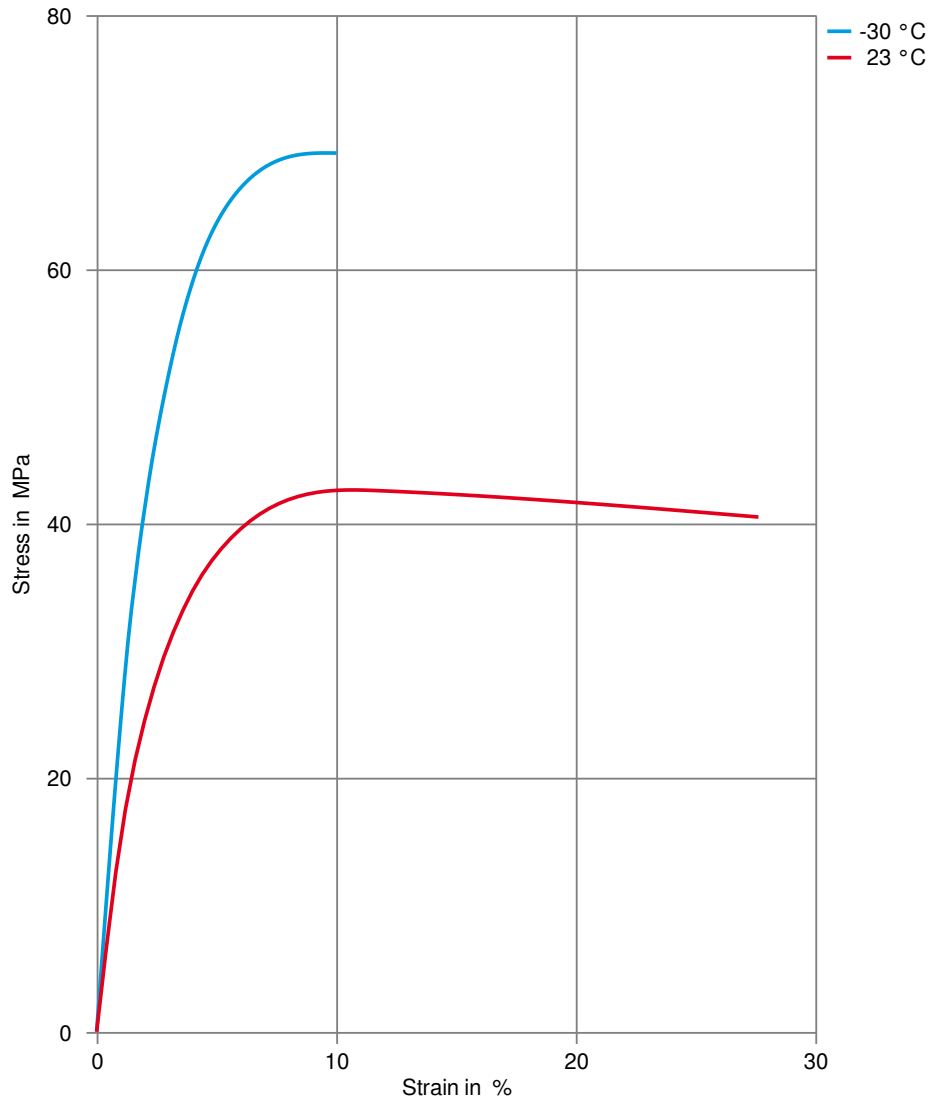
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Shearstress-shear rate



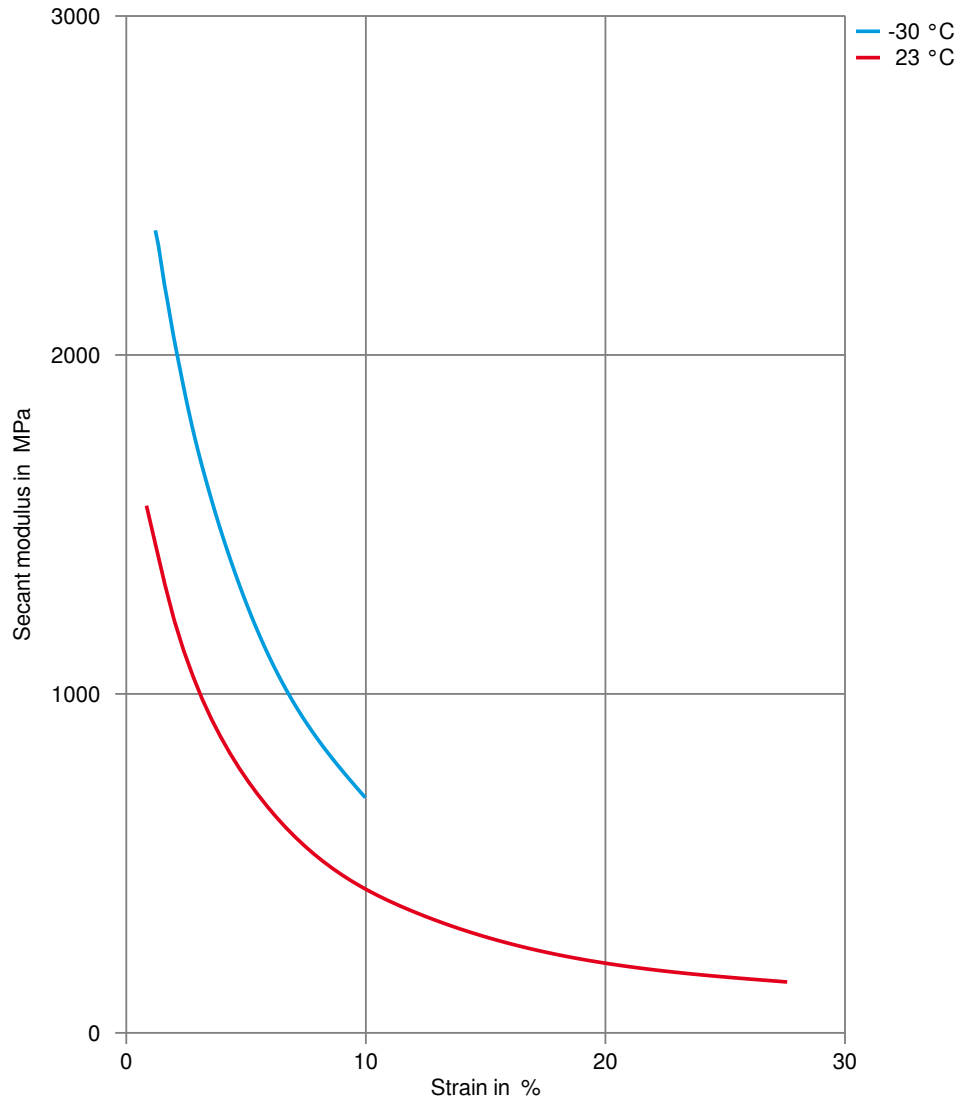
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Stress-strain



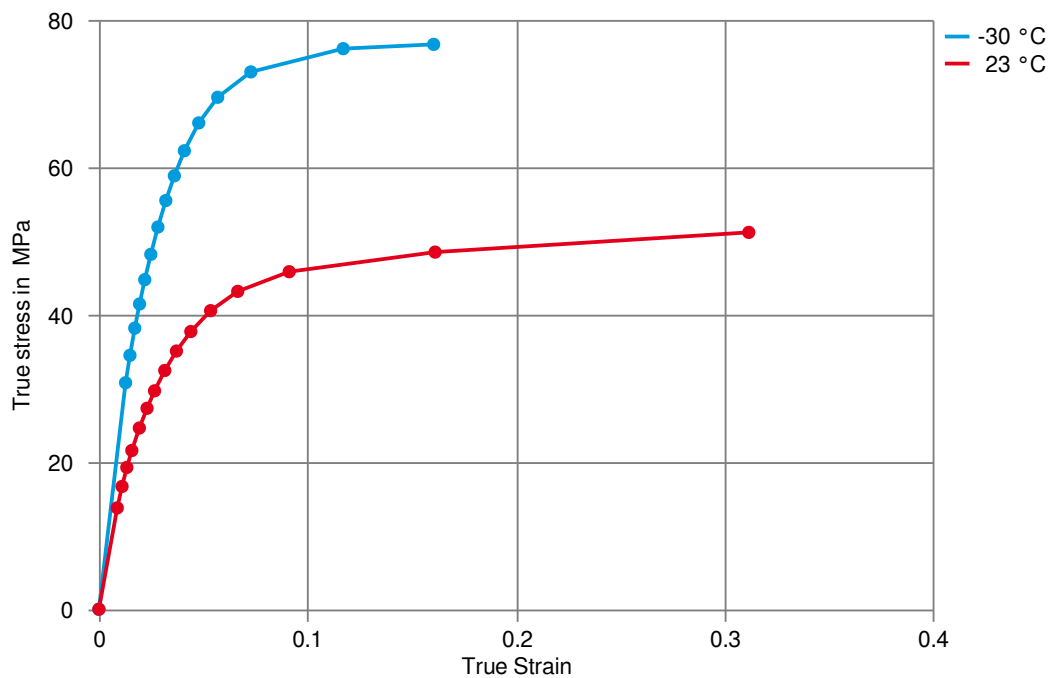
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Secant modulus-strain



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True stress-strain



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Processing Texts

Pre-drying

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.

Longer pre-drying times/storage

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

