
HOSTAFORM® S 9243 XAP²™ LS | 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 for natural and colored grades

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

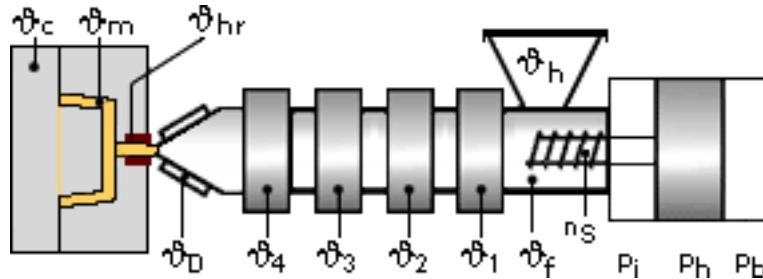
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	1950	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	44	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	9	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	40	%	ISO 527-2/1A
Tensile creep modulus (1h)	1700	MPa	ISO 899-1
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 granules

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

Drying time: 3 - 4 h

Drying temperature: 100 - 120 °C

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

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

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