# HOSTAFORM® C 13021 XAP®2 ECO-C 872
## HOSTAFORM®

POM copolymer Medium flow injection molding grade 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 < 2 mg/kg (natural grades) Emission according to VDA 275 < 5 mg/kg (colored grades)

Hostaform® POM C 13021 XAP®2 ECO-C 872 NATURAL incorporates a minimum of 85% circular content derived from captured carbon dioxide emissions by weight in the finished product through mass balance allocation. The product is a drop-in replacement to the standard grade with the same performance and processing properties and contributes to the displacement of virgin fossil fuel resources. The feedstock utilizing captured carbon dioxide emissions are ISCC CFC certified as low carbon intensity methanol.

## Product information

| | | | |
|---|---|---|---|
| Resin Identification | POM | | ISO 1043 |
| Part Marking Code | >POM< | | ISO 11469 |

## Rheological properties

| | | | |
|---|---|---|---|
| Melt volume-flow rate | 12 | $cm^3$/10min | ISO 1133 |
| Temperature | 374 | °F | |
| Load | 4.76 | lb | |
| Molding shrinkage, parallel | 2.0 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 1.8 | % | ISO 294-4, 2577 |

## Typical mechanical properties

| | | | |
|---|---|---|---|
| Tensile modulus | 399000 | psi | ISO 527-1/-2 |
| Tensile stress at yield, 50mm/min | 9300 | psi | ISO 527-1/-2 |
| Tensile strain at yield, 50mm/min | 9 | % | ISO 527-1/-2 |
| Nominal strain at break | 25 | % | ISO 527-1/-2 |
| Flexural modulus | 392000 | psi | ISO 178 |
| Tensile creep modulus, 1h | 348000 | psi | ISO 899-1 |
| Tensile creep modulus, 1000h | 174000 | psi | ISO 899-1 |
| Charpy impact strength, 23°C | 95.1 | $ftlb/in^2$ | ISO 179/1eU |
| Charpy impact strength, -30°C | 95.1 | $ftlb/in^2$ | ISO 179/1eU |
| Charpy notched impact strength, 23°C | 3.09 | $ftlb/in^2$ | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 2.85 | $ftlb/in^2$ | ISO 179/1eA |

## Thermal properties

| | | | |
|---|---|---|---|
| Melting temperature, 10°C/min | 331 | °F | ISO 11357-1/-3 |
| Coefficient of linear thermal expansion (CLTE), parallel | 0.67 | E-4/°F | ISO 11359-1/-2 |
| Coefficient of linear thermal expansion (CLTE), normal | 0.667 | E-4/°F | ISO 11359-1/-2 |

## Flammability

| | | | |
|---|---|---|---|
| FMVSS Class | B | | ISO 3795 (FMVSS 302) |
| Burning rate, Thickness 1 mm | 1.77 | in/min | ISO 3795 (FMVSS 302) |

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## Electrical properties

| | | | |
|---|---|---|---|
| Relative permittivity, 100Hz | 4 | | IEC 62631-2-1 |
| Relative permittivity, 1MHz | 4 | | IEC 62631-2-1 |
| Dissipation factor, 100Hz | 20 | 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 | 889 | kV/in | IEC 60243-1 |
| Comparative tracking index | 600 | | IEC 60112 |

## Physical/Other properties

| | | | |
|---|---|---|---|
| Humidity absorption, 2mm | 0.2 | % | Sim. to ISO 62 |
| Water absorption, 2mm | 0.65 | % | Sim. to ISO 62 |
| Density | 0.0509 | lb/in$^3$ | ISO 1183 |

## Injection

| | | |
|---|---|---|
| Drying Recommended | no | |
| Drying Temperature | 212 | °F |
| Drying Time, Dehumidified Dryer | 3 - 4 | h |
| Processing Moisture Content | ≤0.2 | % |
| Melt Temperature Optimum | 374 | °F |
| Min. melt temperature | 356 | °F |
| Max. melt temperature | 392 | °F |
| Max. screw tangential speed | ≤0.3 | m/s |
| Mold Temperature Optimum | 212 | °F |
| Min. mold temperature | 176 | °F |
| Max. mold temperature | 248 | °F |
| Hold pressure range | 8700 - 17400 | psi |
| Hold Pressure Time<br>(h is the max. wall thickness of the part in mm) | 2h$^2$-3 | s |
| Back pressure | 580 | psi |

## Automotive

| OEM | STANDARD | ADDITIONAL INFORMATION |
|---|---|---|
| Mercedes-Benz | DBL5404 | BQF |
| VW Group | TL 524 76 | |

## Characteristics

| | |
|---|---|
| Processing | Injection Molding |
| Special characteristics | Low emissions |
| Sustainability | Carbon Capture |

## Additional information

Injection molding

### Preprocessing

To achive 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 %

### Processing

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

### Postprocessing

Conditioning e.g. moisturizing is not necessary.

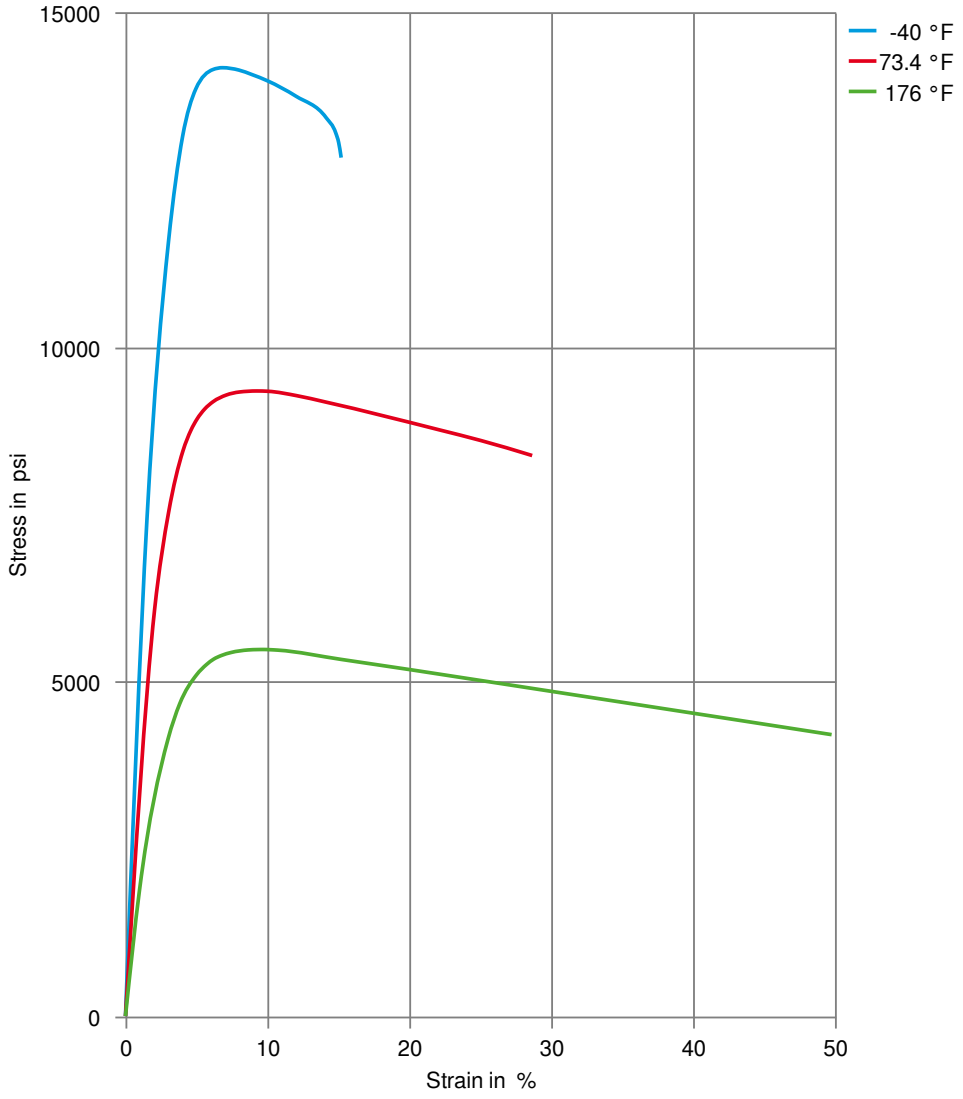
Processing Notes

### Pre-Drying

recommended

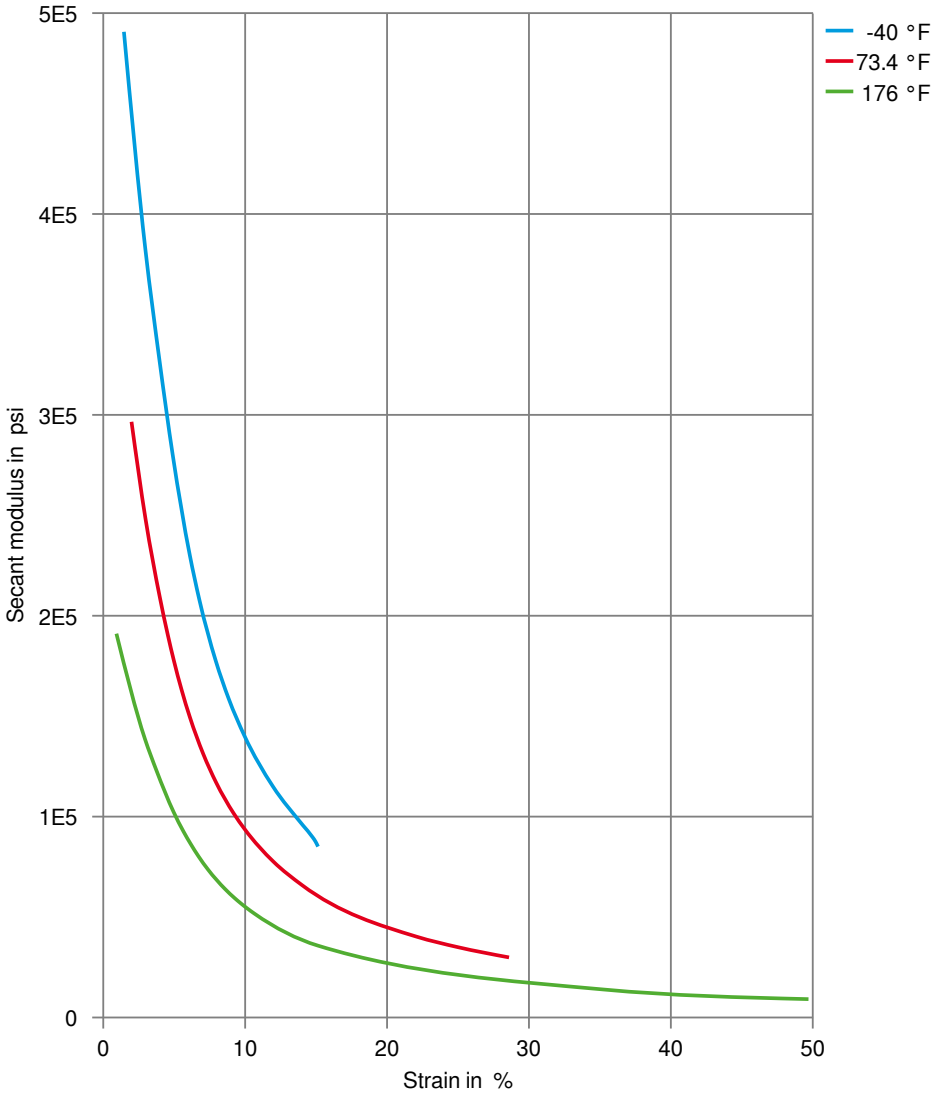
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## Stress-strain



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## Secant modulus-strain






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