HOSTAFORM® LM270Z XAP®2

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Hostaform® acetal copolymer grade LX270Z XAP®2 is a UV stabilized material available in a range of molded in metallic colors generally for automotive interior applications and is a higher flow grade than LX90Z. In addition, Hostaform® LX270Z XAP®2 has lower volatile emissions as required for some automotive interiors. Flow properties of this grade is based upon the uncolored acetal copolymer and flow testing does not reflect how it actually flows. Besides material, optimal finish for specialty metallic parts is dependent on proper drying, gate design, knit line locations, and special processing. Please contact Celanese Technical Service for assistance with your application.

Product information

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

Rheological properties

Melt volume-flow rate	24	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	

Typical mechanical properties

Tensile modulus	377000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	9000	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	7.5	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	2.62	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	327	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	212	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.61	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.611	E-4/°F	ISO 11359-1/-2

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

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Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	580	psi

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	TL 524 76	10/9222 Black

Characteristics

Processing	Injection Molding
Special characteristics	Light stabilized or stable to light, U.V. stabilized or stable to weather, Laser Markable, High Flow, Low emissions

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.

Melt temperature 180-190 °C
Mould temperature 60-120 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

Processing Notes

Pre-Drying

recommended

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