HOSTAFORM® S 27244 XAP®2

HOSTAFORM®

Easy flow, high impact modified injection molding grade, with good low temperature impact strength and good weld line strength and reduced emissions. Emission according to VDA 275 < 5 mg/kg

Preliminary data sheet

Product information

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

Rheological properties

Melt volume-flow rate	4.5	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	

Typical mechanical properties

Tensile modulus	203000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	4900	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8.5	%	ISO 527-1/-2
Nominal strain at break	50	%	ISO 527-1/-2
Charpy impact strength, 23°C	N	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	7.14	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	4.28	$ftlb/in^2$	ISO 179/1eA

Thermal properties

Temperature of deflection under load, 1.8 MPa	156	°F	ISO 75-1/-2

Physical/Other properties

Density	0.0455	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	383	°F
Min. melt temperature	374	°F
Max. melt temperature	392	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	158	°F
Min. mold temperature	140	°F
Max. mold temperature	176	°F
Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	290	psi

Revised: 2025-07-10 Source: Celanese Materials Database

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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5404	BQF

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	High Flow, Low emissions, Improved weld line

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