

HOSTAFORM® LM270Z XAP®2

Laser markable polyacetalcopolymer easy flow injection molding grade with reduced emissions especially for automotive interior application. With Improved UV resistance. Burning rate according to FMVSS 302 < 100 mm/min (1 mm thickness). Emission according to VDA 275 < 5 mg/kg. Preliminary Datasheet

Rheological properties

Melt volume-flow rate	24 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	

Typical mechanical properties

Tensile Modulus	2600 MPa	ISO 527-1/-2
Yield stress, 50mm/min	62 MPa	ISO 527-1/-2
Yield strain, 50mm/min	7.5 %	ISO 527-1/-2
Charpy notched impact strength, 23°C	5.5 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	164 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	110 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	110 E-6/K	ISO 11359-1/-2

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.65 %	Sim. to ISO 62
Density	1410 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	80 - 120 °C
Back pressure	4 MPa
Injection speed	slow-medium

Additional information

Injection molding

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

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Processing Texts

Pre-drying	recommended
Injection molding	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
Injection molding Preprocessing	To achieve 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 %
Injection molding Postprocessing	Conditioning e.g. moisturizing is not necessary.

Other Approvals

Other Approvals	OEM	Specification	Additional Information
	VW Group	TL 524 76	10/9222 Black