

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 24 cm³/10min Melt volume-flow rate ISO 1133 190 °C Temperature Load 2.16 kg Typical mechanical properties 2600 MPa **Tensile Modulus** 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/m² ISO 179/1eA Thermal properties 164 °C Melting temperature, 10°C/min ISO 11357-1/-3 100 °C Temp. of deflection under load, 1.8 MPa ISO 75-1/-2 ISO 11359-1/-2 Coeff. of linear therm. expansion, parallel 110 E-6/K Coeff. of linear therm. expansion, normal 110 E-6/K ISO 11359-1/-2 Other properties 0.2 % Sim. to ISO 62 Humidity absorption, 2mm Water absorption, 2mm 0.65 % Sim. to ISO 62 Density 1410 kg/m³ ISO 1183 Injection **Drving 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 4 MPa Back pressure slow-medium Injection speed 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 plasticating screws will fit.	e (15 to 25 D)	
	Melt temperature 180-190 °C Mould temperature 60-120 °C		
Injection molding Preprocessing	To achive low emission values pre drying using a recirculating air dryer (100 to 120 $^{\circ}$ 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

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