HOSTAFORM® S 27244 XAP®2

Impact Modified, low Emission
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

Rheological properties

Melt volume-flow rate	4.5	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile Modulus	1400	MPa	ISO 527-1/-2
Yield stress, 50mm/min	34	MPa	ISO 527-1/-2
Yield strain, 50mm/min	8.5	%	ISO 527-1/-2
Nominal strain at break	50	%	ISO 527-1/-2
Charpy impact strength, 23°C	NB	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	15	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	9	kJ/m^2	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	69	°C	ISO 75-1/-2

Other properties

Density	1260	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	60 - 80	°C
Back pressure	2	MPa
Injection speed	slow-medium	

Characteristics

Additives	Release agent

Other Approvals

Other Approvals

OEM	Specification	Additional Information
Mercedes-Benz Group (Daimler)	DBL 5404	BQF

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Revised: 2023-02-23 Source: Celanese Materials Database