HOSTAFORM® XGC25 XAP®

High strength glass coupled
Hostaform® XGC25 XAP® is an acetal copolymer reinforced with approximately 25% glass fibers. Compared to the Hostaform® C 9021 GV 1/30, Hostaform® XGC25 XAP® has a higher strength and lower emissions.

ISO 29988-POM-K,(GF25),EM,0-3

Rheological properties

Melt volume-flow rate	2	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	9000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	155	MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.5	%	ISO 527-1/-2
Flexural Modulus	8300	MPa	ISO 178
Compressive stress at 1% strain	85	MPa	ISO 604
Shear Modulus	1740	MPa	ISO 6721
Charpy impact strength, 23°C	70	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	13	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	11	kJ/m^2	ISO 179/1eA
Hardness, Rockwell, M-scale	96		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	160	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	166	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	30	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	60	E-6/K	ISO 11359-1/-2

Other properties

Water absorption, 2mm	0.9	%	Sim. to ISO 62
Density	1580	kg/m^3	ISO 1183

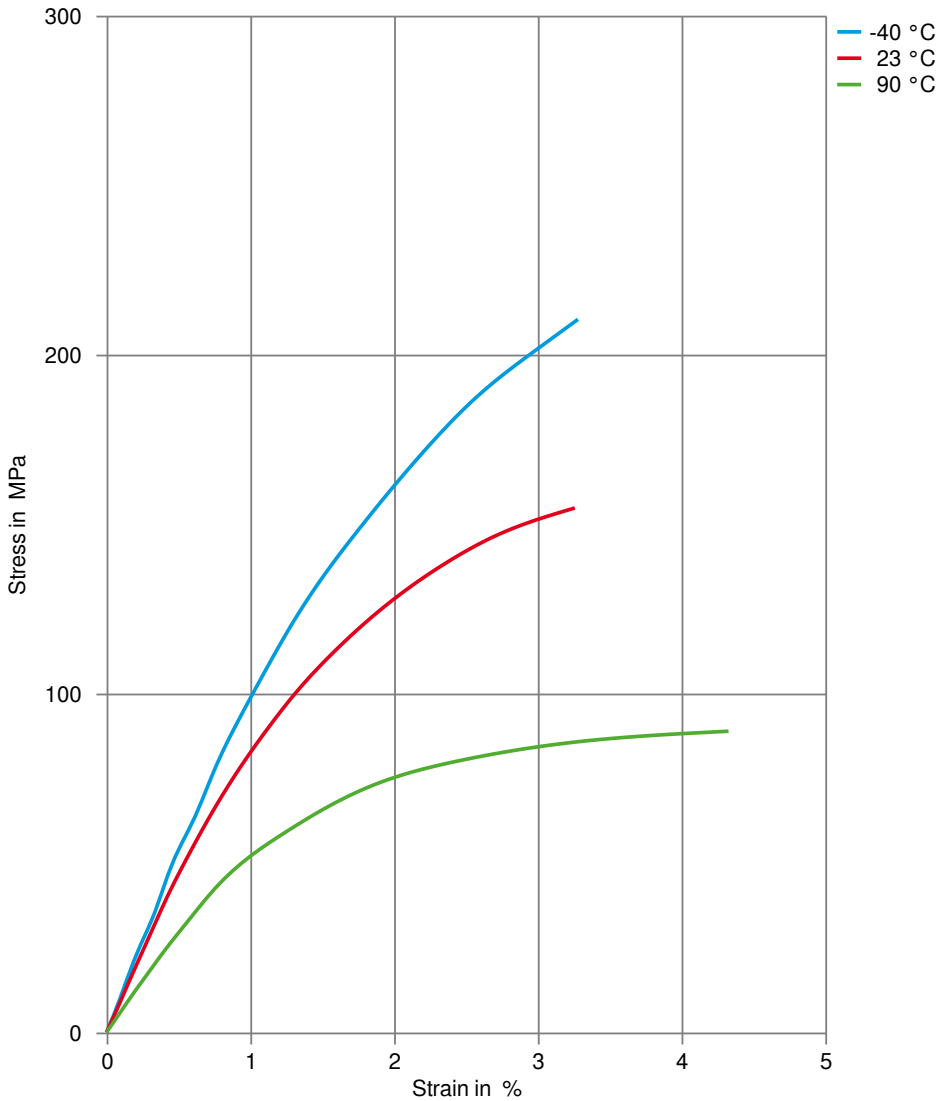
Injection

Drying Temperature	100 - 120	°C	
Drying Time, Dehumidified Dryer	3 - 4	h	
Processing Moisture Content	0.15	%	
Melt Temperature Optimum	210	°C	Internal
Screw tangential speed	0.2 - 0.21	m/s	
Max. mould temperature	80 - 120	°C	

HOSTAFORM® XGC25 XAP®

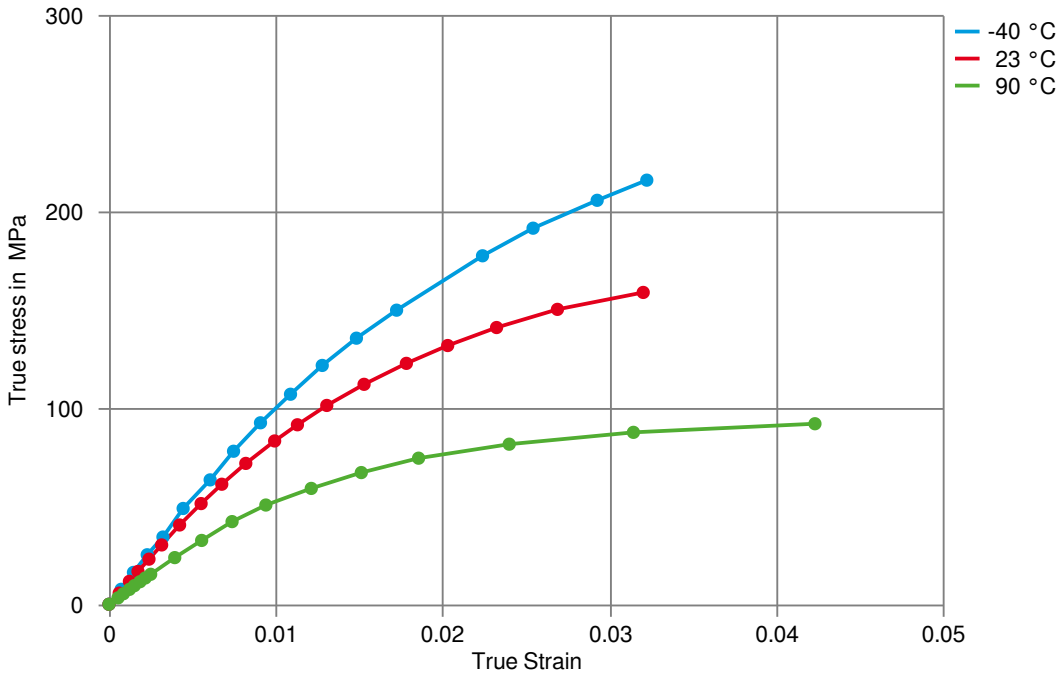
Back pressure	2 MPa
Injection speed	slow

Stress-strain



HOSTAFORM® XGC25 XAP®

True stress-strain



HOSTAFORM® XGC25 XAP®

Processing Texts

Pre-drying	Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.
Longer pre-drying times/storage	The product can then be stored in standard conditions until processed.

Revised: 2023-07-21 Source: Celanese Materials Database