HOSTAFORM® XGC25 EF XAP®2

HOSTAFORM®

High strength glass coupled, easy flow
Hostaform® XGC25 EF XAP®2 is an easy flowing injection molding grade with approximately 25% glass fibers and reduced emission.
Emissions according to VDA 275 < 5ppm [mg/kg]

Product information

Resin Identification	POM-GF25	ISO 1043
Part Marking Code	>POM-GF25<	ISO 11469

Rheological properties

Melt volume-flow rate	5	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.31E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	22500	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3	%	ISO 527-1/-2
Charpy impact strength, 23°C	30.9	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	5.23	$ftlb/in^2$	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	320	°F	ISO 75-1/-2

Physical/Other properties

Density	0.057	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	392	°F
Min. melt temperature	374	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°F
Max. mold temperature	248	°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
Ejection temperature	275	°F

Revised: 2024-07-08 Source: Celanese Materials Database

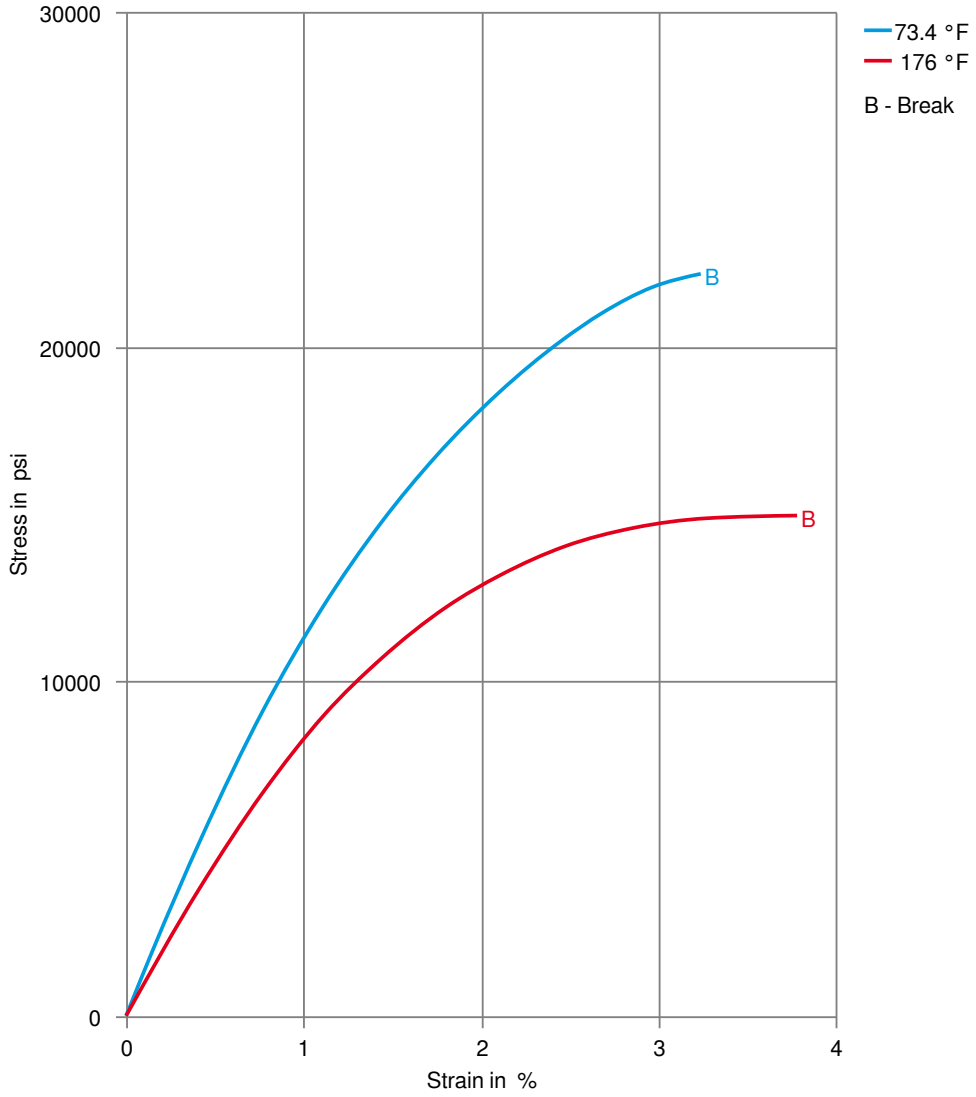
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Characteristics

Processing	Injection Molding
Special characteristics	High Flow, Low emissions

Stress-strain

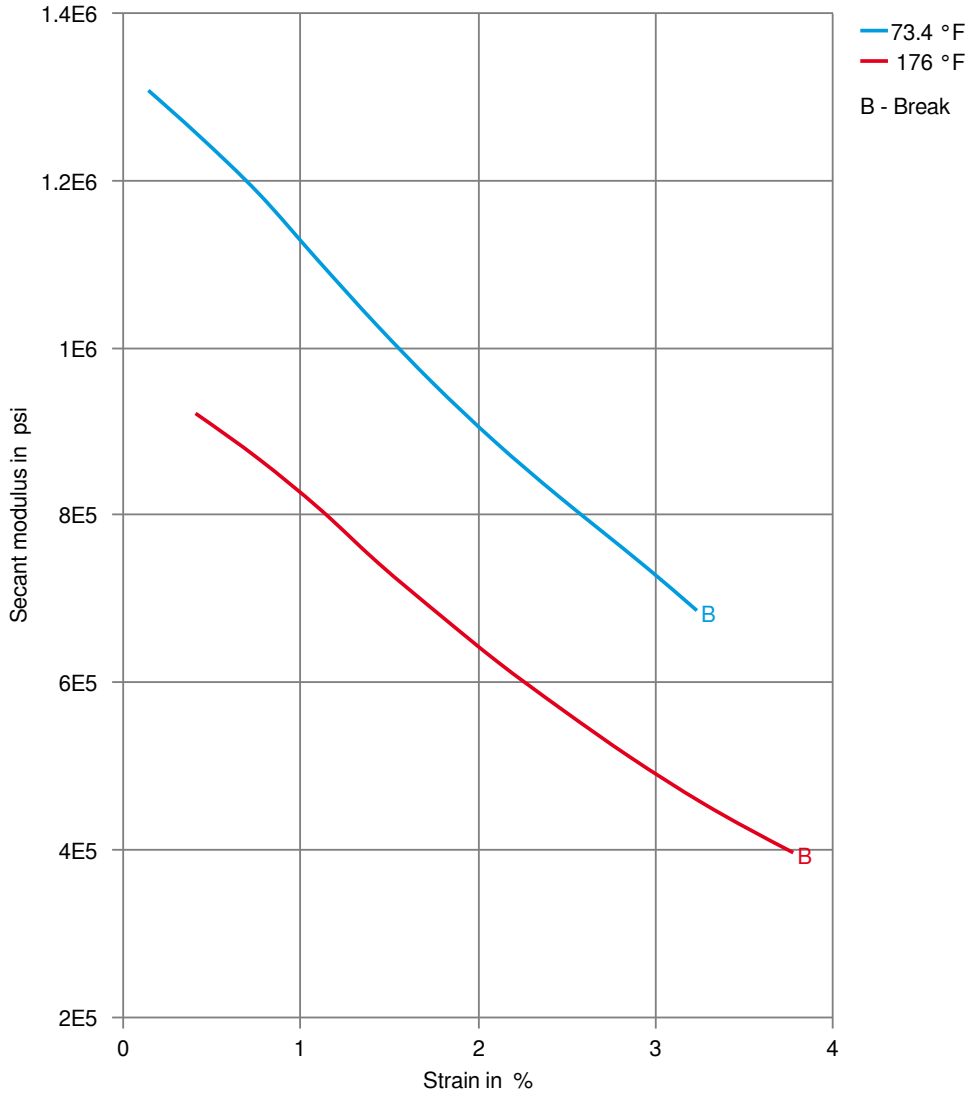


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Secant modulus-strain



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