HOSTAFORM® XGC25 XAP®

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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

Product information

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

Rheological properties

Melt volume-flow rate	2	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	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	3.5	%	ISO 527-1/-2
Flexural modulus	1.2E6	psi	ISO 178
Compressive stress at 1% strain	12300	psi	ISO 604
Charpy impact strength, 23°C	33.3	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	6.18	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	5.23	$ftlb/in^2$	ISO 179/1eA
Hardness, Rockwell, M-scale	96		ISO 2039-2

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
Temperature of deflection under load, 0.45 MPa	331	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.17	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.333	E-4/°F	ISO 11359-1/-2

Physical/Other properties

Water absorption, 2mm	0.9	%	Sim. to ISO 62
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

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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	279	°F

Characteristics

Processing	Injection Molding
Special characteristics	Low emissions

Additional information

Processing Notes

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.

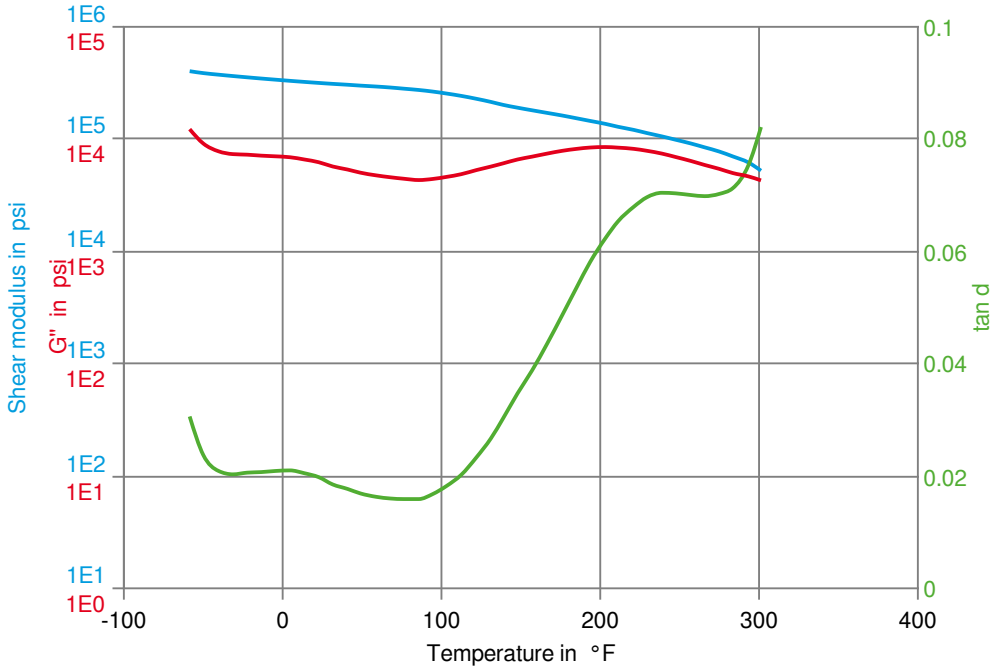
Storage

The product can then be stored in standard conditions until processed.

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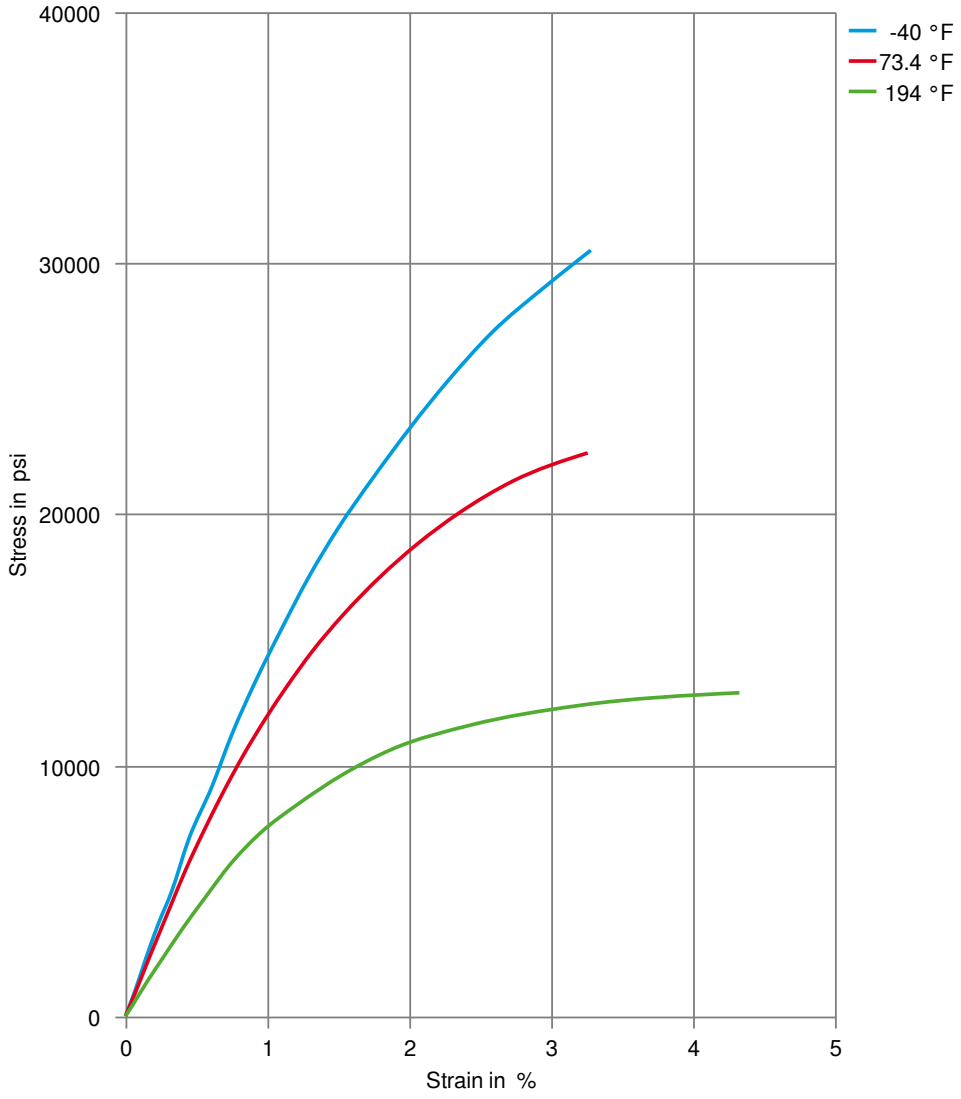
Dynamic Shear modulus-temperature



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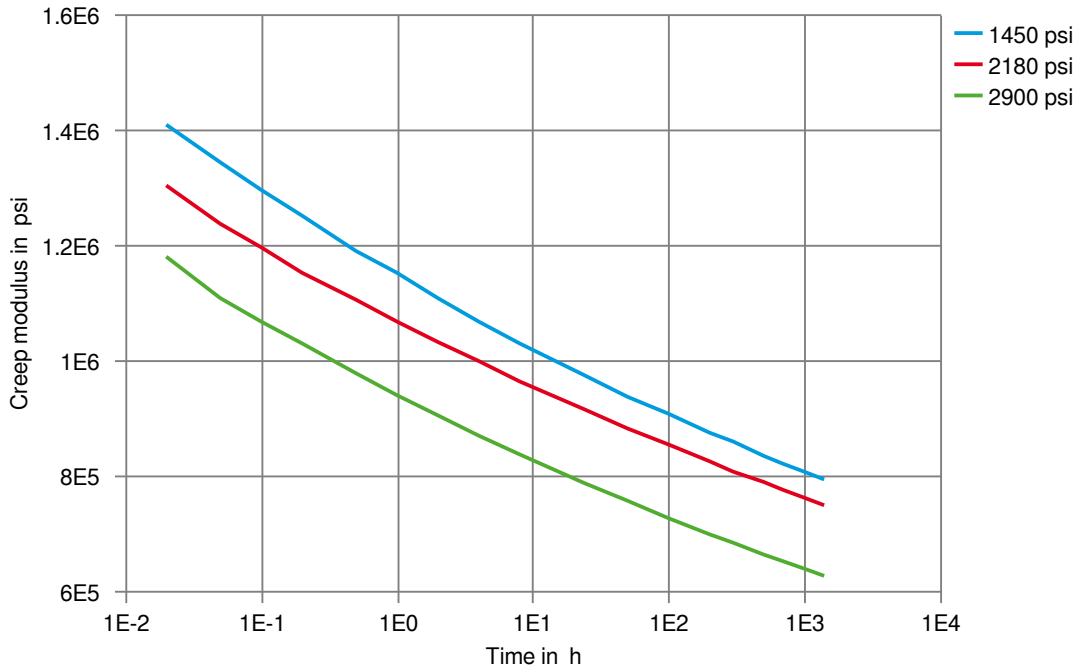
Stress-strain



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Creep modulus-time 194 °F

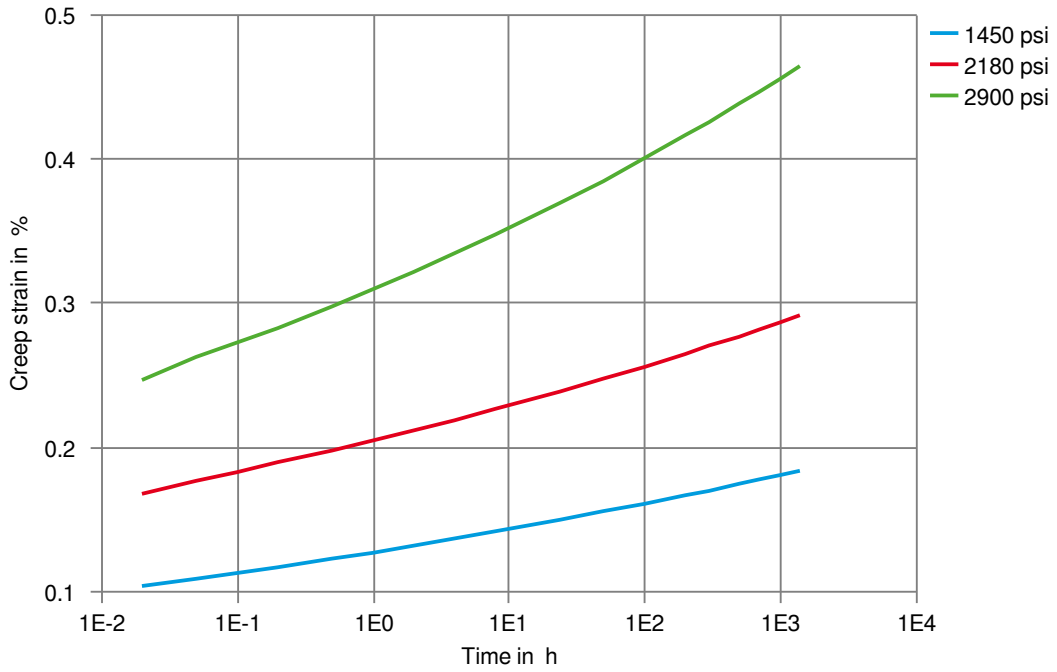


Revised: 2025-01-24 Source: Celanese Materials Database

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Creep strain-time 194 °F



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