Hostaform® XGC10 XAP

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

Hostaform® XGC10XAP is a Polyacetalcopolymer reinforced with approx. 10% glass fibres. Compared to the Hostaform® C 9021 GV 1/10 Hostaform® XGC10XAP has a higher strength and lower emissions.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Bead, 10% Filler by Weight		
Features	• Good Strength	• Low Emissions	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.0	%	
Flow	1.4	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	682000	psi	ISO 527-2/1A
Tensile Stress (Break)	16000	psi	ISO 527-2/1A/5
Tensile Strain (Break)	4.9	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	609000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	4.0	ft·lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	29	ft·lb/in²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	309	°F	ISO 75-2/A
Melting Temperature [2]	331	°F	ISO 11357-3
CLTE - Flow	3.3E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	4.4E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 410	°F
Processing (Melt) Temp	374 to 410	°F
Mold Temperature	176 to 248	°F

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Injection	Nominal Value	Unit
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 190 to 210°C
Hot runner temperature: 190 to 210°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 10°C/min