

HOSTAFORM® XGC10 XAP®

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Hostaform® XGC10 XAP® is an acetal copolymer reinforced with approximately 10% glass fibers. Compared to the Hostaform® C 9021 GV 1/10, Hostaform® XGC10 XAP® has a higher strength and lower emissions.
Emissions according to VDA 275 < 10 ppm [mg/kg].

Product information

| | | |
|----------------------|------------|-----------|
| Resin Identification | POM-GF10 | ISO 1043 |
| Part Marking Code | >POM-GF10< | ISO 11469 |

Rheological properties

| | | |
|------------------------------|--------------------------|-----------------|
| Melt volume-flow rate | 3 cm ³ /10min | ISO 1133 |
| Temperature | 190 °C | |
| Load | 2.16 kg | |
| Moulding shrinkage, parallel | 1.2 % | ISO 294-4, 2577 |
| Moulding shrinkage, normal | 1.1 % | ISO 294-4, 2577 |

Typical mechanical properties

| | | |
|--|-----------------------|--------------|
| Tensile modulus | 4800 MPa | ISO 527-1/-2 |
| Tensile stress at break, 5mm/min | 110 MPa | ISO 527-1/-2 |
| Tensile strain at break, 5mm/min | 4.9 % | ISO 527-1/-2 |
| Flexural modulus | 4200 MPa | ISO 178 |
| Charpy impact strength, 23 °C | 60 kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, 23 °C | 8.5 kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30 °C | 7 kJ/m ² | ISO 179/1eA |
| Poisson's ratio | 0.36 ^[C] | |

[C]: Calculated

Thermal properties

| | | |
|--|----------|----------------|
| Melting temperature, 10 °C/min | 166 °C | ISO 11357-1/-3 |
| Temperature of deflection under load, 1.8 MPa | 154 °C | ISO 75-1/-2 |
| Coefficient of linear thermal expansion (CLTE), parallel | 60 E-6/K | ISO 11359-1/-2 |
| Coefficient of linear thermal expansion (CLTE), normal | 80 E-6/K | ISO 11359-1/-2 |

Flammability

| | | |
|------------------------------|-------------|----------------------|
| FMVSS Class | B | ISO 3795 (FMVSS 302) |
| Burning rate, Thickness 1 mm | 66.3 mm/min | ISO 3795 (FMVSS 302) |

Physical/Other properties

| | | |
|---------|------------------------|----------|
| Density | 1480 kg/m ³ | ISO 1183 |
|---------|------------------------|----------|

Injection

| | |
|---------------------------------|---------|
| Drying Recommended | no |
| Drying Temperature | 100 °C |
| Drying Time, Dehumidified Dryer | 3 - 4 h |
| Processing Moisture Content | ≤0.2 % |
| Melt Temperature Optimum | 200 °C |

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| | |
|--------------------------|--------------|
| Min. melt temperature | 190 °C |
| Max. melt temperature | 210 °C |
| Screw tangential speed | ≤0.3 m/s |
| Mold Temperature Optimum | 100 °C |
| Min. mould temperature | 80 °C |
| Max. mould temperature | 120 °C |
| Hold pressure range | 60 - 120 MPa |
| Back pressure | 2 MPa |
| Ejection temperature | 134 °C |

Characteristics

| | |
|-------------------------|--------------------|
| Processing | Injection Moulding |
| 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.

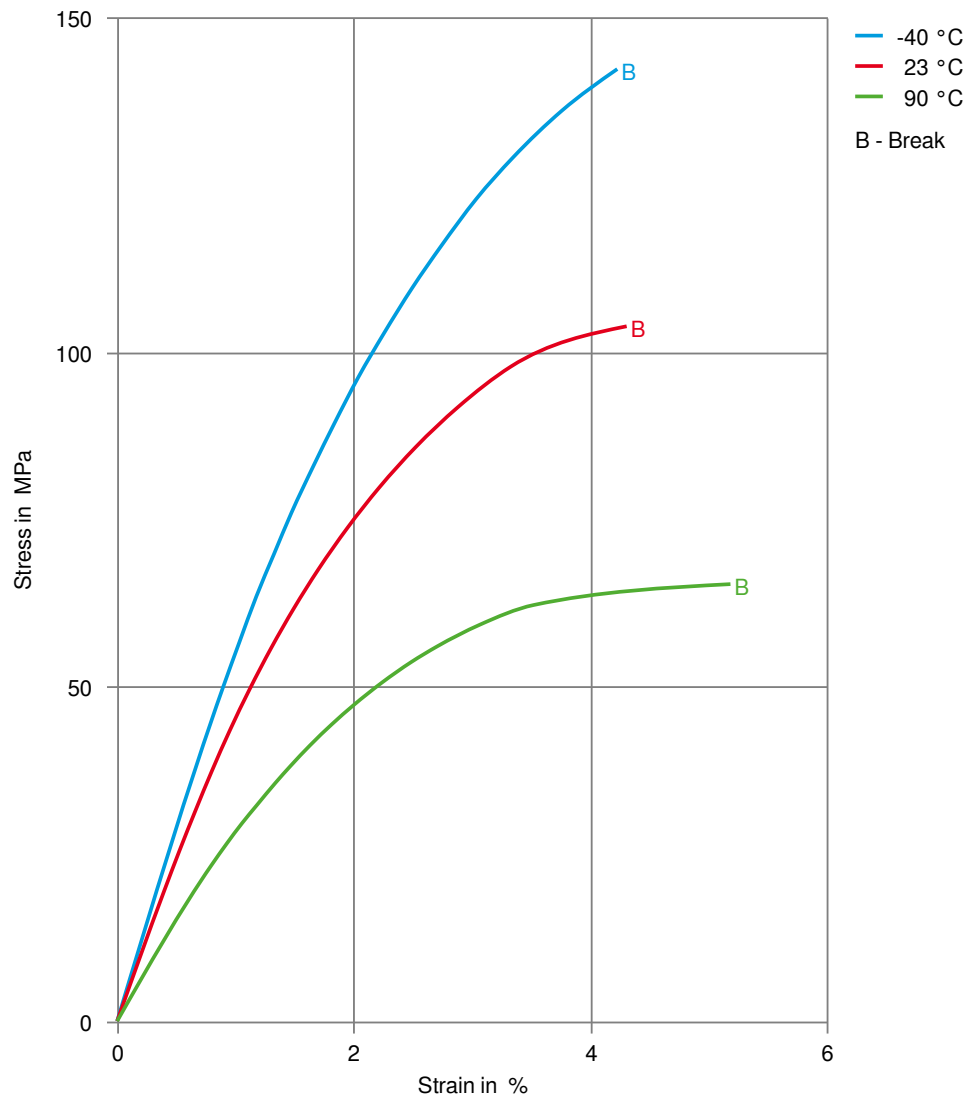
Storage

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

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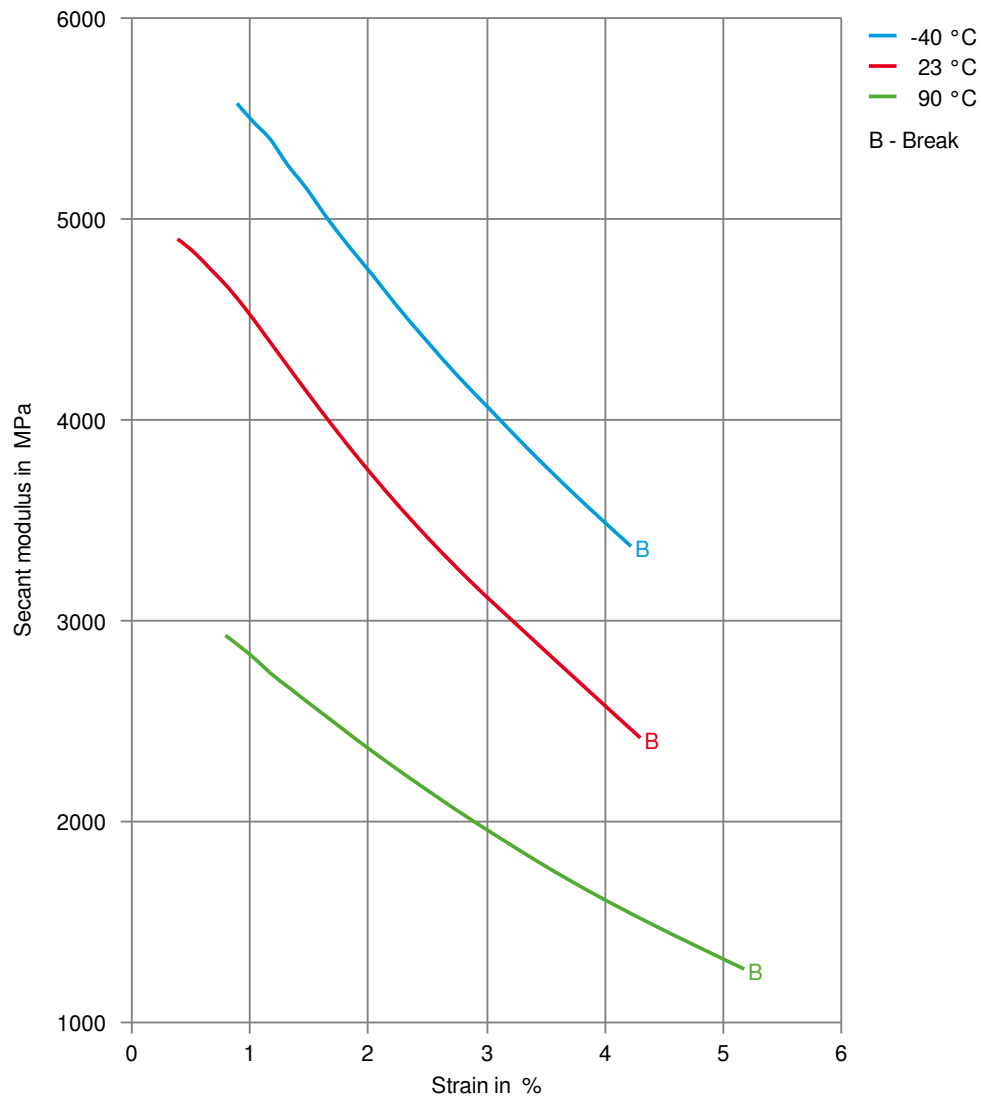
Stress-strain



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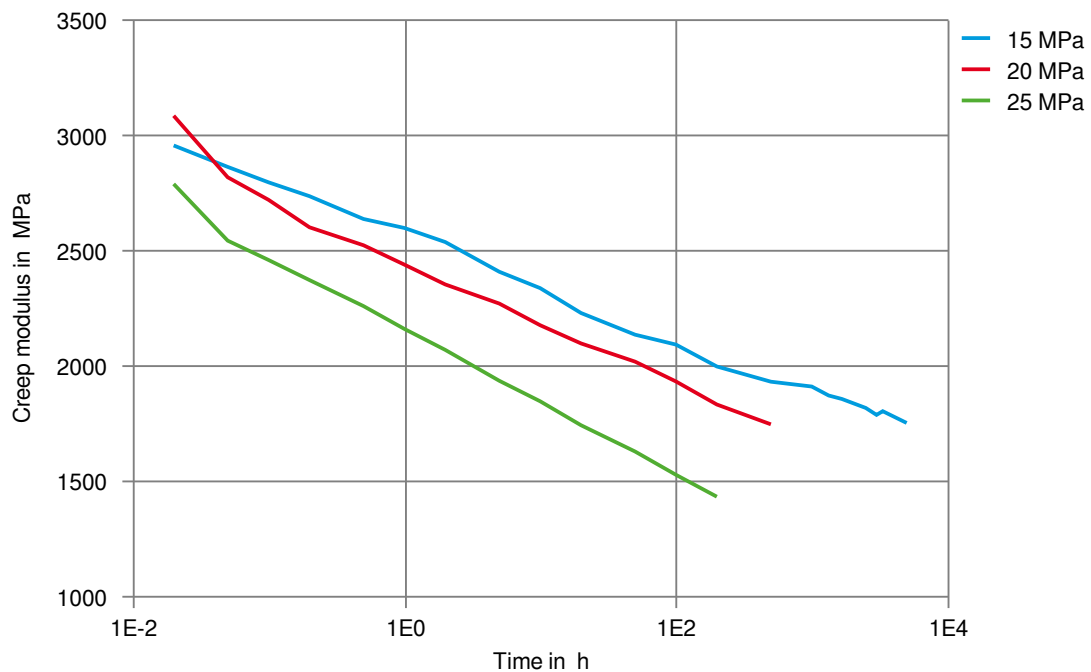
Secant modulus-strain



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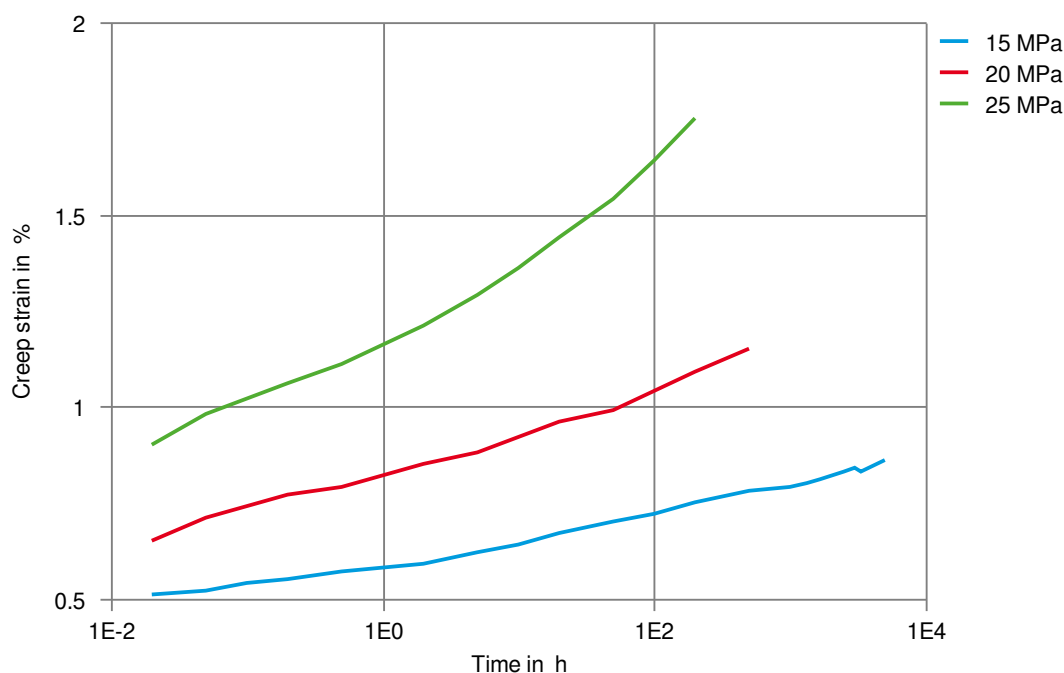
Creep modulus-time 90°C



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Creep strain-time 90 °C



Printed: 2025-05-30

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Revised: 2025-04-18 Source: Celanese Materials Database

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