Celanese
The chemistry inside innovation™

HOSTAFORM® XGC40 - POM

Experimental Grade. Please contact your Celanese representative for further information.

Description

Hostaform® XGC40 is a Polyacetalcopolymer reinforced with approx. 40% glass fibres.

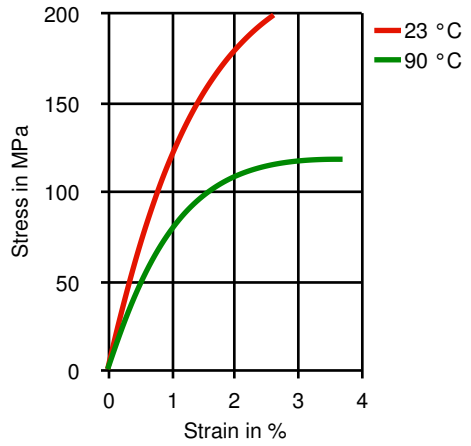
Physical properties	Value	Unit	Test Standard
Density	**1730**	kg/m³	ISO 1183
Molding shrinkage, parallel	**0.4**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.8**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**15000**	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	**200**	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	**2.8**	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	**13**	kJ/m²	ISO 179/1eA

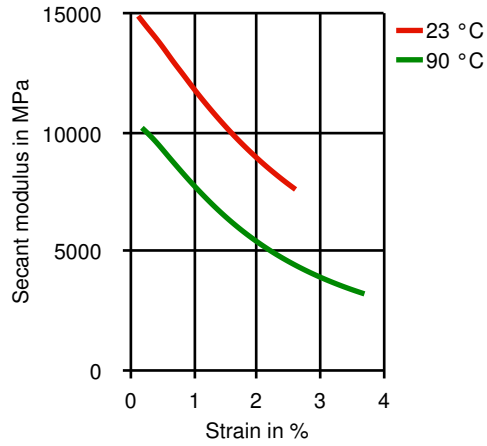
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	**166**	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	**163**	°C	ISO 75-1, -2

Diagrams

Stress-strain



Secant modulus-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	**0.15**	%	-
Drying time	**3 - 4**	h	-
Drying temperature	**100 - 120**	°C	-
Temperature	**Value**	**Unit**	**Test Standard**
Hopper temperature	**20 - 30**	°C	-
Feeding zone temperature	**60 - 80**	°C	-
Zone1 temperature	**170 - 180**	°C	-
Zone2 temperature	**180 - 190**	°C	-
Zone3 temperature	**190 - 200**	°C	-
Zone4 temperature	**190 - 210**	°C	-
Nozzle temperature	**190 - 210**	°C	-
Melt temperature	**190 - 210**	°C	-
Mold temperature	**80 - 120**	°C	-

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Hot runner temperature	**190 - 210**	°C	-
Pressure	**Value**	**Unit**	**Test Standard**
Back pressure max.	**20**	bar	-
Speed	**Value**	**Unit**	**Test Standard**
Injection speed	**slow**	-	-
Screw Speed	**Value**	**Unit**	**Test Standard**
Screw speed diameter, 25mm	**150**	RPM	-
Screw speed diameter, 40mm	**100**	RPM	-
Screw speed diameter, 55mm	**70**	RPM	-

Other text information

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.

Characteristics

Product Categories

Glass reinforced

Contact Information

General Disclaimer

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