

Hostaform® XT 20

Acetal (POM) Copolymer

Celanese Corporation

Message:

Preliminary Data Sheet

Hostaform® acetal copolymer grade XT 20 is highly impact modified grade for very demanding applications. Hostaform® XT 20 provides exceptional impact strength and flexibility over standard impact modified acetal grades.

Chemical abbreviation according to ISO 1043-1: POM-HI

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Impact resistance, good		
	Good flexibility		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	POM-HI		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.2	%	ISO 294-4
Flow direction	1.4	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1200	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	35.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	25	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	15	kJ/m ²	ISO 179/1eA
23°C	100	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	124	°C	ISO 75-2/B
1.8 MPa, not annealed	64.0	°C	ISO 75-2/A

Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.2E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	180 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	60.0 - 80.0	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 0.500	MPa	
Injection instructions			
Zone 4 Temperature: 180 to 200°C			
NOTE			
1.	10°C/min		

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