



Hostaform® XT 20

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

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

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• Good Flexibility	• Good Impact Resistance	• Impact Modified
RoHS Compliance	• Contact Manufacturer		
Resin ID (ISO 1043)	• POM-HI		

ASTM & ISO Properties ¹

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
Across Flow	1.2	%	
Flow	1.4	%	
Water Absorption (Saturation, 73°F)	0.80	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	174000	psi	ISO 527-2/1A
Tensile Stress (Yield)	5080	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	25	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	160000	psi	ISO 178
Flexural Stress (3.5% Strain)	4500	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	7.1	ft-lb/in ²	
73°F	48	ft-lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	No Break		
73°F	No Break		
Notched Izod Impact Strength			ISO 180/1A
-40°F	6.7	ft-lb/in ²	
73°F	40	ft-lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	255	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	147	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3
Melting Temperature	329	°F	

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Thermal	Nominal Value	Unit	Test Method
CLTE - Flow	6.7E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.7E-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
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	356 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	140 to 176	°F
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Zone4 temperature: 180 to 200°C
 No flow temperature: 165°C

Notes

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

² 10°C/min