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HOSTAFORM® XT 20

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Hostaform® acetal copolymer grade XT 20 is a highly impact modified grade for demanding applications. Hostaform® XT 20 provides exceptional impact strength and flexibility over standard impact modified acetal copolymer grades. Chemical abbreviation according to ISO 1043-1: POM-HI

Product information

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469

Rheological properties

Melt volume-flow rate	1	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	1.4	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1200	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	35	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	25	%	ISO 527-1/-2
Flexural modulus	1100	MPa	ISO 178
Flexural stress at 3.5%	31	MPa	ISO 178
Charpy impact strength, 23°C	N	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	100	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	15	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	85	kJ/m^2	ISO 180/1A
Izod notched impact strength, -40°C	14.0	kJ/m^2	ISO 180/1A
Hardness, Rockwell, M-scale	39		ISO 2039-2
Poisson's ratio	0.498		

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	64	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	124	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	120	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	120	E-6/K	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.25	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	Sim. to ISO 62
Density	1330	kg/m^3	ISO 1183

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Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	195	°C
Min. melt temperature	180	°C
Max. melt temperature	210	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	70	°C
Min. mould temperature	60	°C
Max. mould temperature	80	°C
Hold pressure range	60 - 120	MPa
Back pressure	2	MPa
Ejection temperature	126	°C

Characteristics

Processing	Injection Moulding, Extrusion, Blow Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	High impact or impact modified

Additional information

Processing Notes

Pre-Drying

Drying is suggested specially if material has come in contact with moisture through storage, handling or regrind use. Dry to prevent splay and odor problems.

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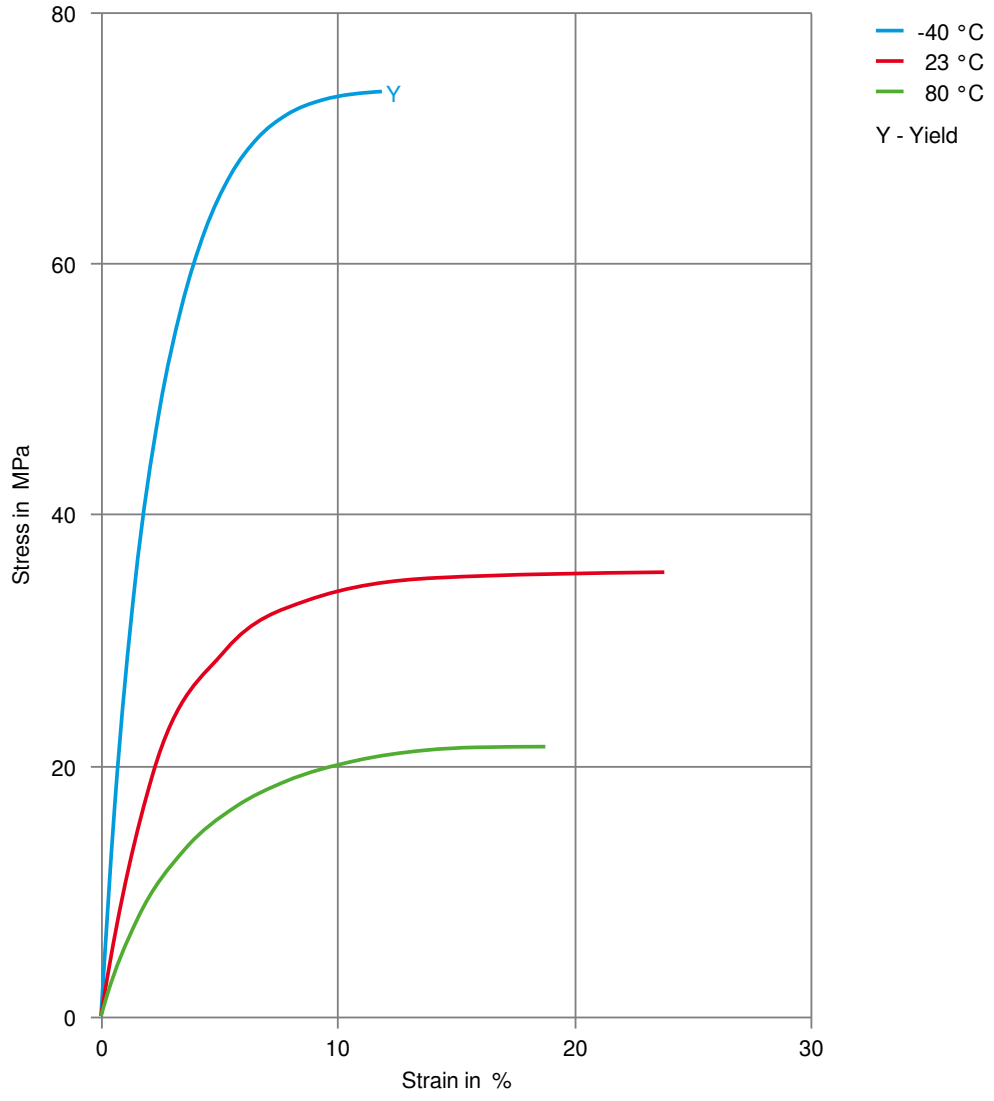
Stress-strain



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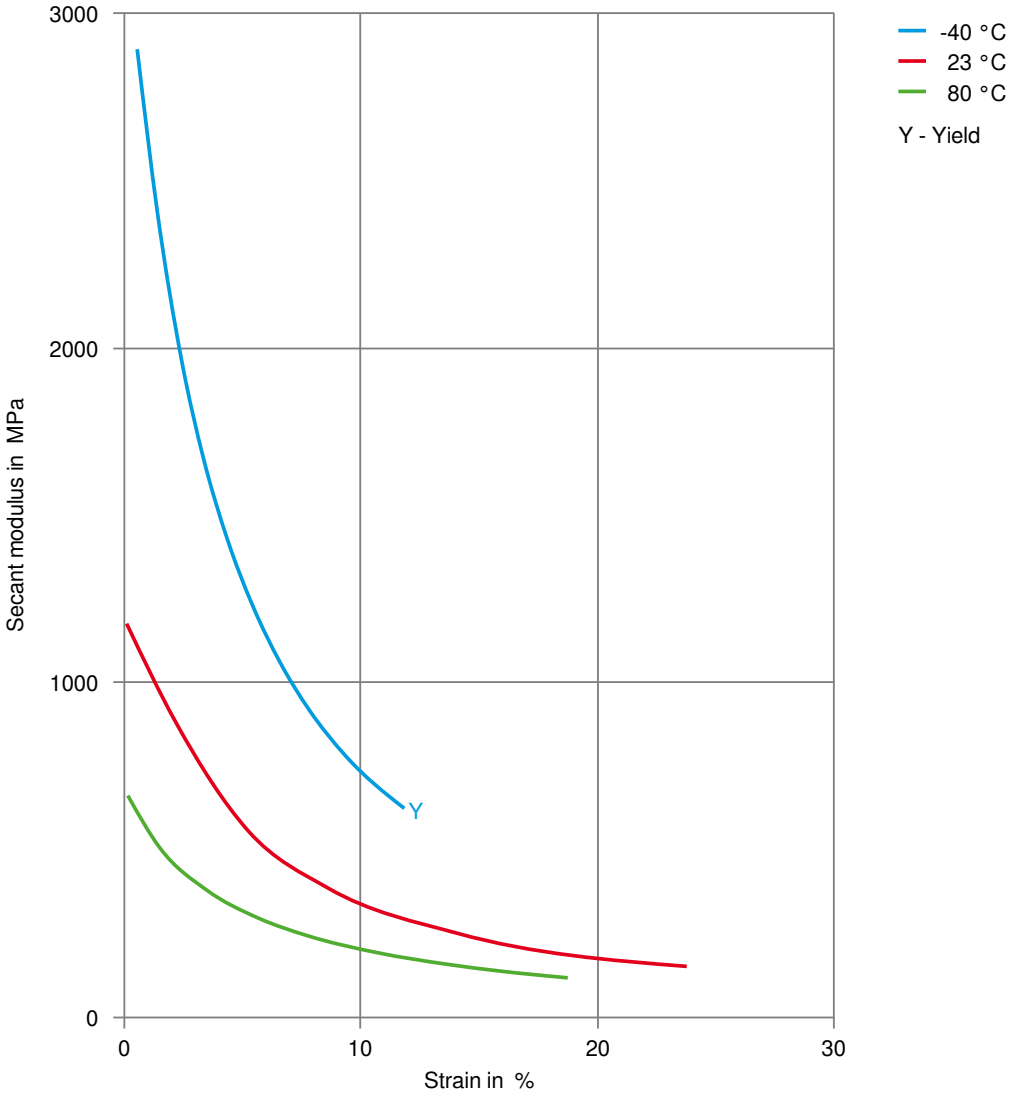
Secant modulus-strain



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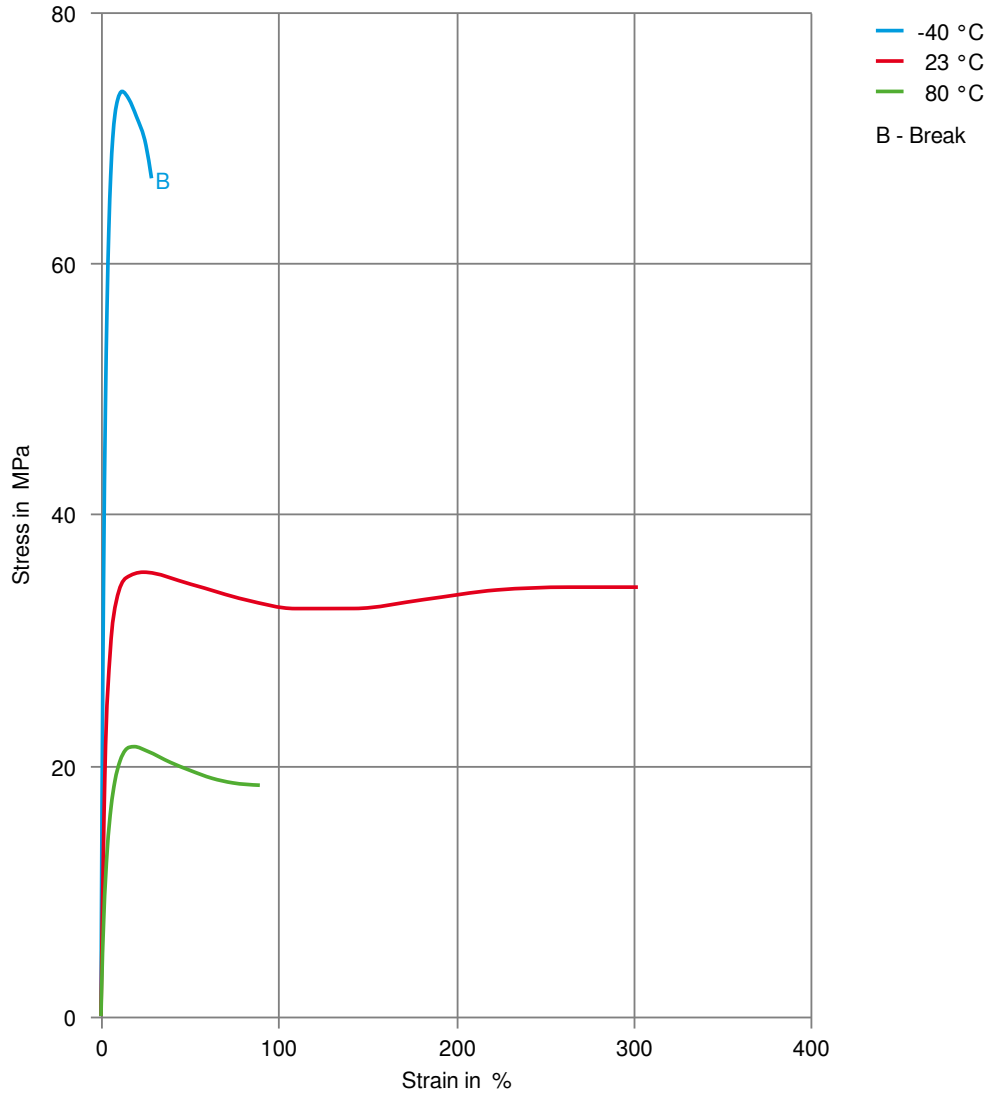
Stress-strain, 50mm/min



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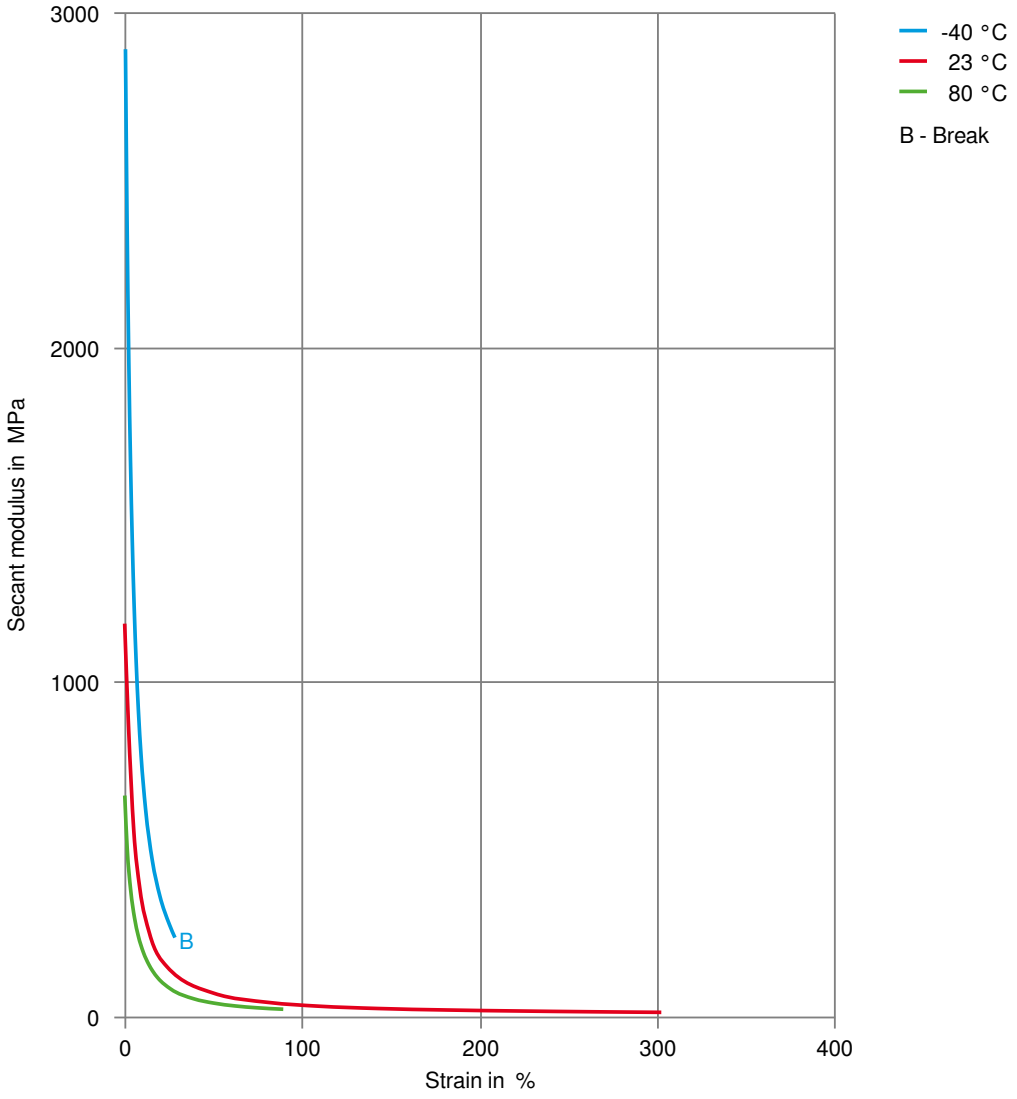
Secant modulus-strain, 50mm/min



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