Celanese
The chemistry inside innovation™

HOSTAFORM® XT 20

Highly Impact Modified
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

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
Yield stress, 50mm/min	35	MPa	ISO 527-1/-2
Yield strain, 50mm/min	25	%	ISO 527-1/-2
Flexural Modulus	1100	MPa	ISO 178
Flexural Stress at 3.5%	31	MPa	ISO 178
Shear Modulus	440	MPa	ISO 6721
Charpy impact strength, 23°C	NB	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	NB	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	kJ/m^2	ISO 180/1A
Poisson's ratio	0.498		

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	64	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	124	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120	E-6/K	ISO 11359-1/-2

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 Temperature	100 - 120	°C	
Drying Time, Dehumidified Dryer	3 - 4	h	
Melt Temperature Optimum	200	°C	Internal
Max. mould temperature	60 - 80	°C	
Back pressure	2	MPa	
Injection speed	slow		

Characteristics

Additives	Release agent

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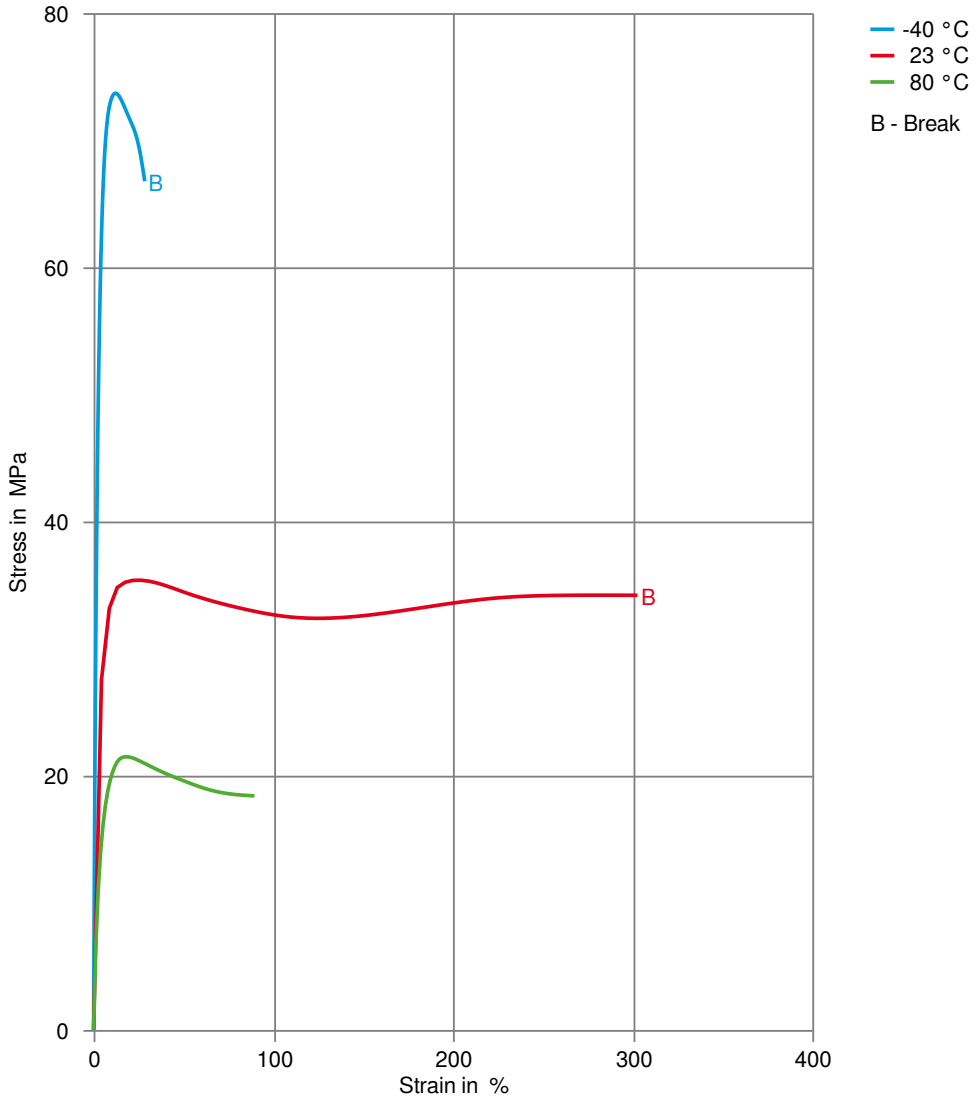
Stress-strain



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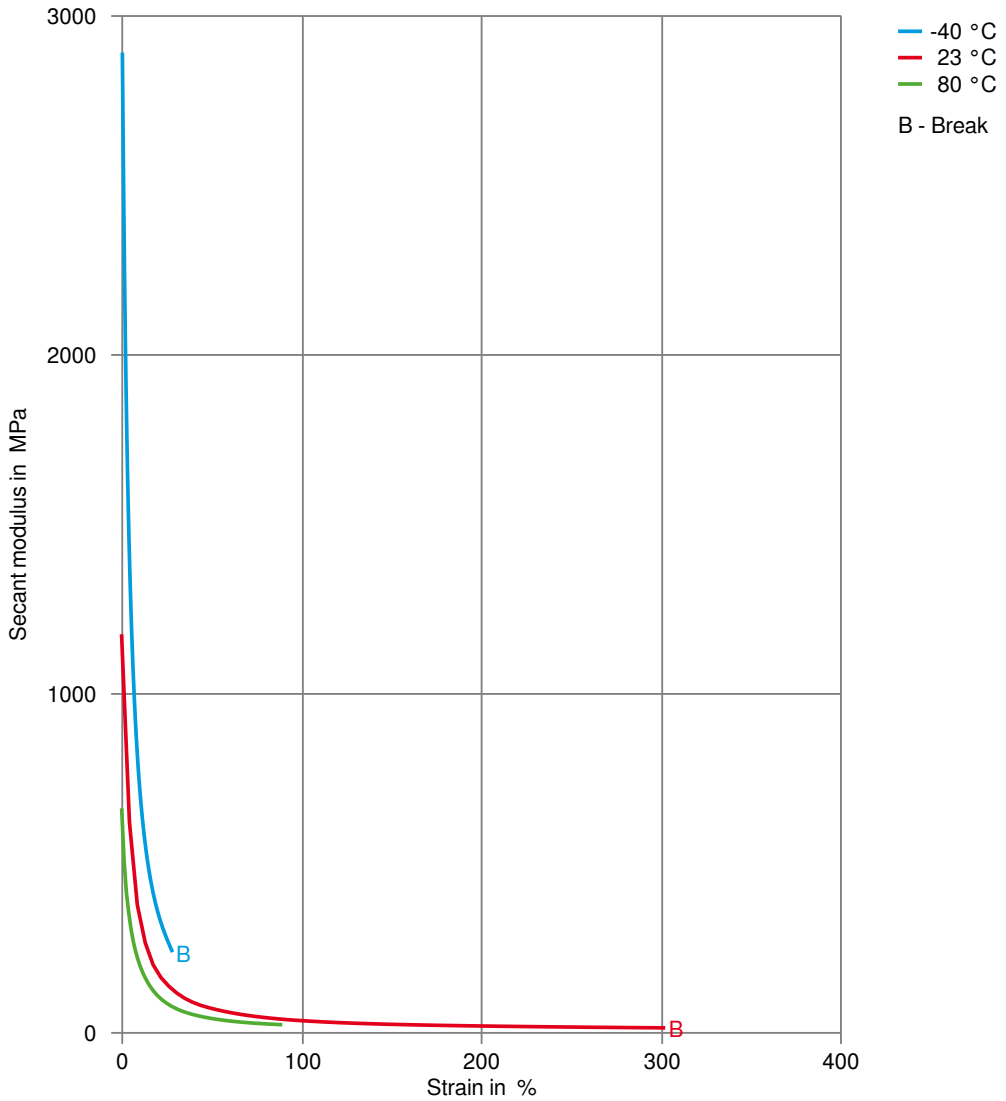
Secant modulus-strain



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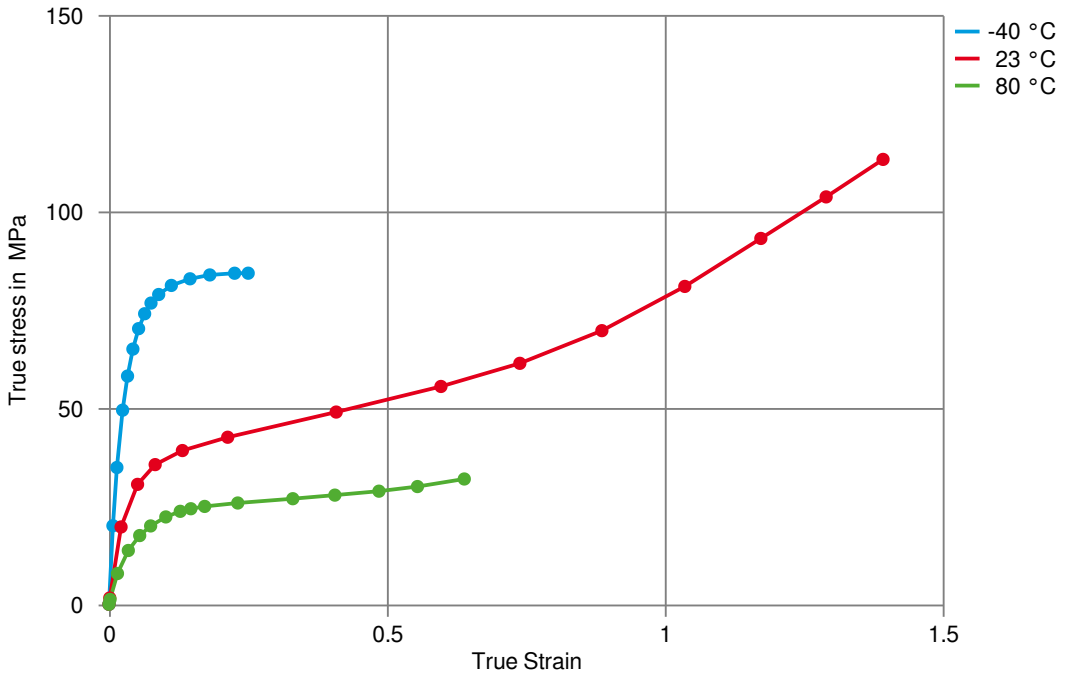
True stress-strain



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Processing Texts

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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