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-HI		ISO 1043
Part Marking Code	>POM-HI<		ISO 11469

Rheological properties

Melt volume-flow rate	1	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	1.4	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	174000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	5100	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	25	%	ISO 527-1/-2
Flexural modulus	160000	psi	ISO 178
Flexural stress at 3.5%	4500	psi	ISO 178
Charpy impact strength, 23°C	N	$ftlb/in^2$	ISO 179/1eU
Charpy impact strength, -30°C	N	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	47.6	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	7.14	$ftlb/in^2$	ISO 179/1eA
Izod notched impact strength, 23°C	40.4	$ftlb/in^2$	ISO 180/1A
Izod notched impact strength, -40°C	6.66	$ftlb/in^2$	ISO 180/1A
Hardness, Rockwell, M-scale	39		ISO 2039-2
Poisson's ratio	0.498		

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	147	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	255	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.67	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.667	E-4/°F	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	0.048	lb/in^3	ISO 1183

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Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	383	°F
Min. melt temperature	356	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	158	°F
Min. mold temperature	140	°F
Max. mold temperature	176	°F
Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	290	psi
Ejection temperature	259	°F

Characteristics

Processing	Injection Molding, Extrusion, Blow Molding
Additives	Release agent
Special characteristics	High impact or impact modified

Additional information

Processing Notes

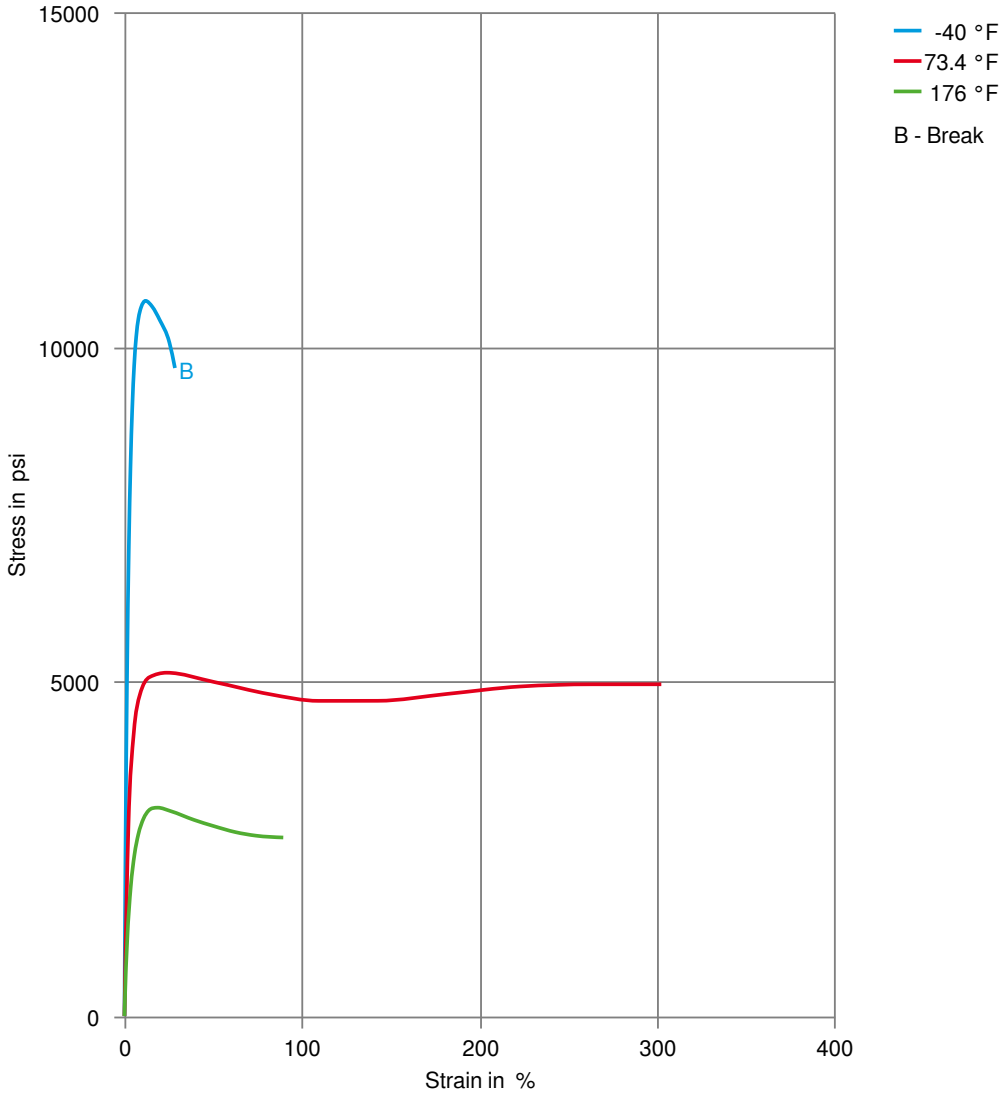
Pre-Drying

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

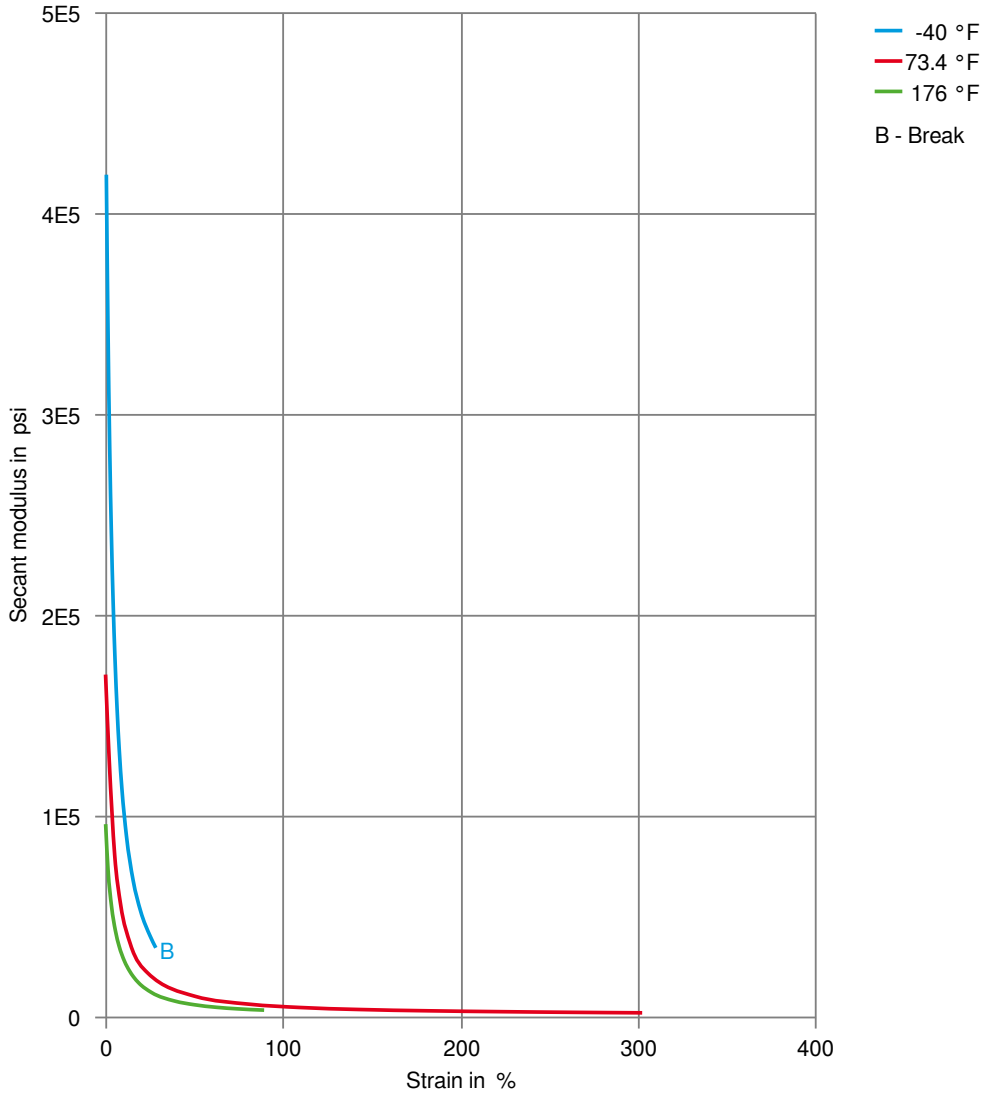


Revised: 2025-07-21 Source: Celanese Materials Database

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Secant modulus-strain



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NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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