

# Hostaform® XT 90

Acetal (POM) Copolymer

Celanese Corporation

## Message:

### Preliminary Data Sheet

Hostaform® acetal copolymer grade XT 90 is highly impact modified grade for very demanding applications. Hostaform® XT 90 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                                     | 1.32                    | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (190°C/2.16 kg) | 2.00                    | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage                           |                         |                        | ISO 294-4       |
| Vertical flow direction                     | 1.1                     | %                      | ISO 294-4       |
| Flow direction                              | 1.2                     | %                      | ISO 294-4       |
| Water Absorption (Saturation, 23°C)         | 0.80                    | %                      | ISO 62          |
| Mechanical                                  | Nominal Value           | Unit                   | Test Method     |
| Tensile Modulus                             | 950                     | MPa                    | ISO 527-2/1A/1  |
| Tensile Stress (Yield)                      | 30.0                    | MPa                    | ISO 527-2/1A/50 |
| Tensile Strain (Yield)                      | 30                      | %                      | ISO 527-2/1A/50 |
| Flexural Modulus (23°C)                     | 950                     | MPa                    | ISO 178         |
| Impact                                      | Nominal Value           | Unit                   | Test Method     |
| Charpy Notched Impact Strength              |                         |                        | ISO 179/1eA     |
| -30°C                                       | 15                      | kJ/m <sup>2</sup>      | ISO 179/1eA     |
| 23°C                                        | 100                     | kJ/m <sup>2</sup>      | 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                      | 115                     | °C                     | ISO 75-2/B      |
| 1.8 MPa, not annealed                       | 60.0                    | °C                     | ISO 75-2/A      |

|                                      |               |          |             |
|--------------------------------------|---------------|----------|-------------|
| Melting Temperature <sup>1</sup>     | 166           | °C       | ISO 11357-3 |
| Linear thermal expansion coefficient |               |          | ISO 11359-2 |
| Flow                                 | 1.0E-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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