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**HOSTAFORM® XT 90 | POM | Impact Modified**


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**Description**


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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

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1320</b>	kg/m <sup>3</sup>	ISO 1183
Melt volume rate (MVR)	<b>2</b>	cm <sup>3</sup> /10min	ISO 1133
MVR test temperature	<b>190</b>	°C	ISO 1133
MVR test load	<b>2.16</b>	kg	ISO 1133
Mold shrinkage - parallel	<b>1.2</b>	%	ISO 294-4
Mold shrinkage - normal	<b>1.1</b>	%	ISO 294-4
Water absorption (23°C-sat)	<b>0.8</b>	%	ISO 62

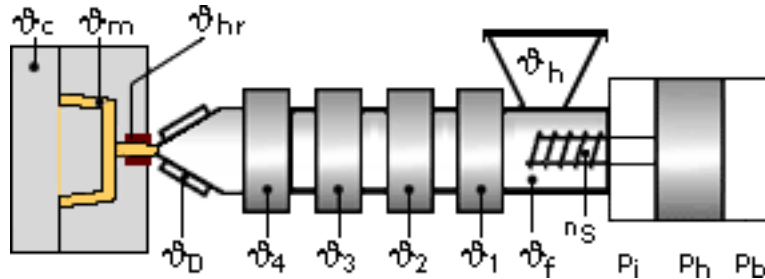
<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile modulus (1mm/min)	<b>950</b>	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	<b>30</b>	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	<b>30</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>950</b>	MPa	ISO 178
Charpy impact strength @ 23°C	<b>NB</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength @ -30°C	<b>NB</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>100.0</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength @ -30°C	<b>15.0</b>	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Melting temperature (10°C/min)	<b>166</b>	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	<b>60</b>	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	<b>115</b>	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	<b>1</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>1.2</b>	E-4/°C	ISO 11359-2

<b>Test specimen production</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Processing conditions acc. ISO	<b>9988-2</b>	-	Internal

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**Typical injection moulding processing conditions**

**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.

**Drying time: 3 h**

**Drying temperature: 80 - 100 °C**

**Temperature:**

	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1
min (°C)	60	180	180	180	180	180	170
max (°C)	80	200	200	200	190	190	180

**Pressure:**

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	5

**Speed:**

**Injection speed: slow**

**Special Info:**

Do not heat over 205 C (~400 F) to avoid burning and discoloring product.

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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. 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.

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