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HOSTAFORM® TF-10XAP®

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Hostaform® acetal copolymer TF-10 XAP® is a low emission, improved flow, impact modified grade providing optimum performance in injection molding, and primarily for the interior automotive market. This grade provides overall excellent performance with improved impact in many applications.

Product information

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

Rheological properties

Melt volume-flow rate	13	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	2.1	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1750	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	48	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	13	%	ISO 527-1/-2
Flexural modulus	1700	MPa	ISO 178
Flexural stress at 3.5%	46	MPa	ISO 178
Charpy notched impact strength, 23°C	8	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m^2	ISO 179/1eA
Hardness, Rockwell, M-scale	65		ISO 2039-2
Poisson's ratio	0.41[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	75	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	139	°C	ISO 75-1/-2

Physical/Other properties

Density	1380	kg/m^3	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	190	°C
Min. melt temperature	180	°C
Max. melt temperature	200	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	90	°C
Min. mould temperature	80	°C
Max. mould temperature	100	°C

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Hold pressure range	60 - 120	MPa
Back pressure	2	MPa
Ejection temperature	133	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	High impact or impact modified, Low emissions

Additional information

Processing Notes

Pre-Drying

Drying is recommended.

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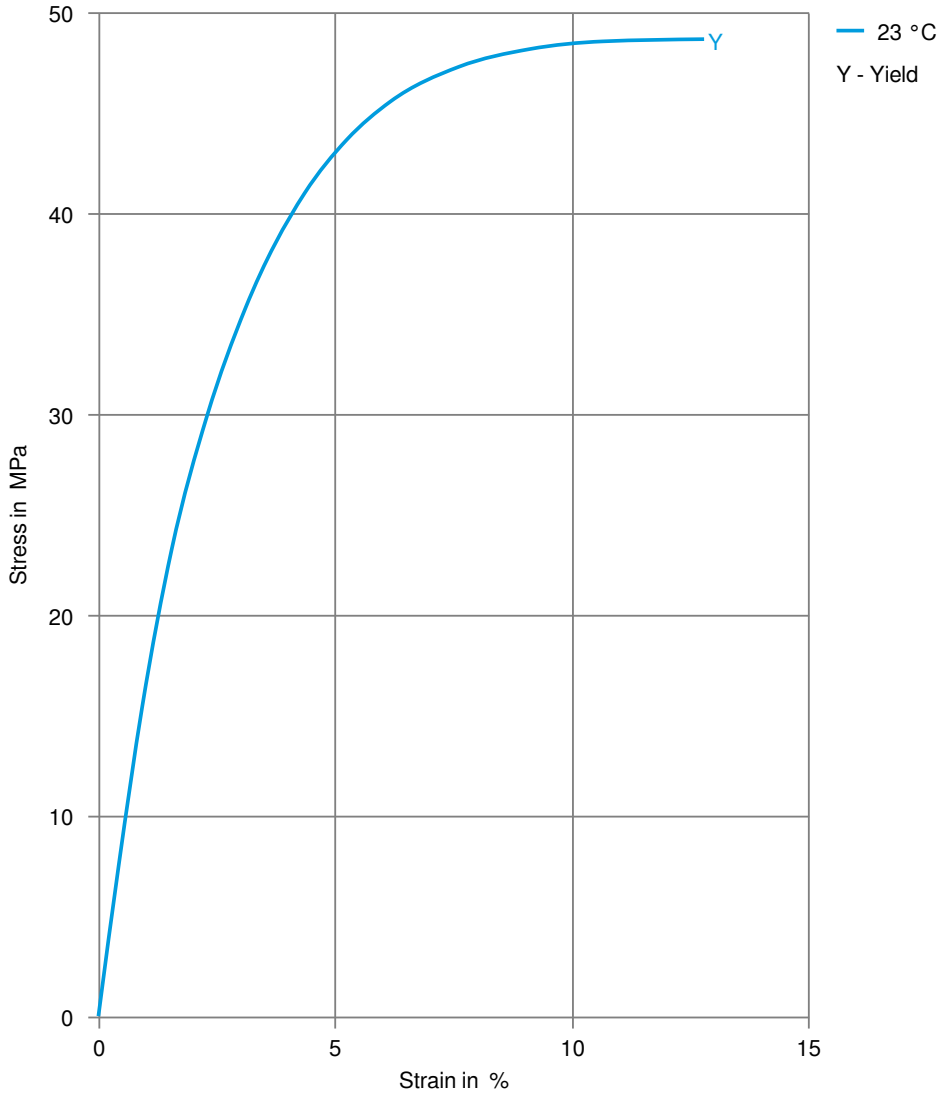
Stress-strain



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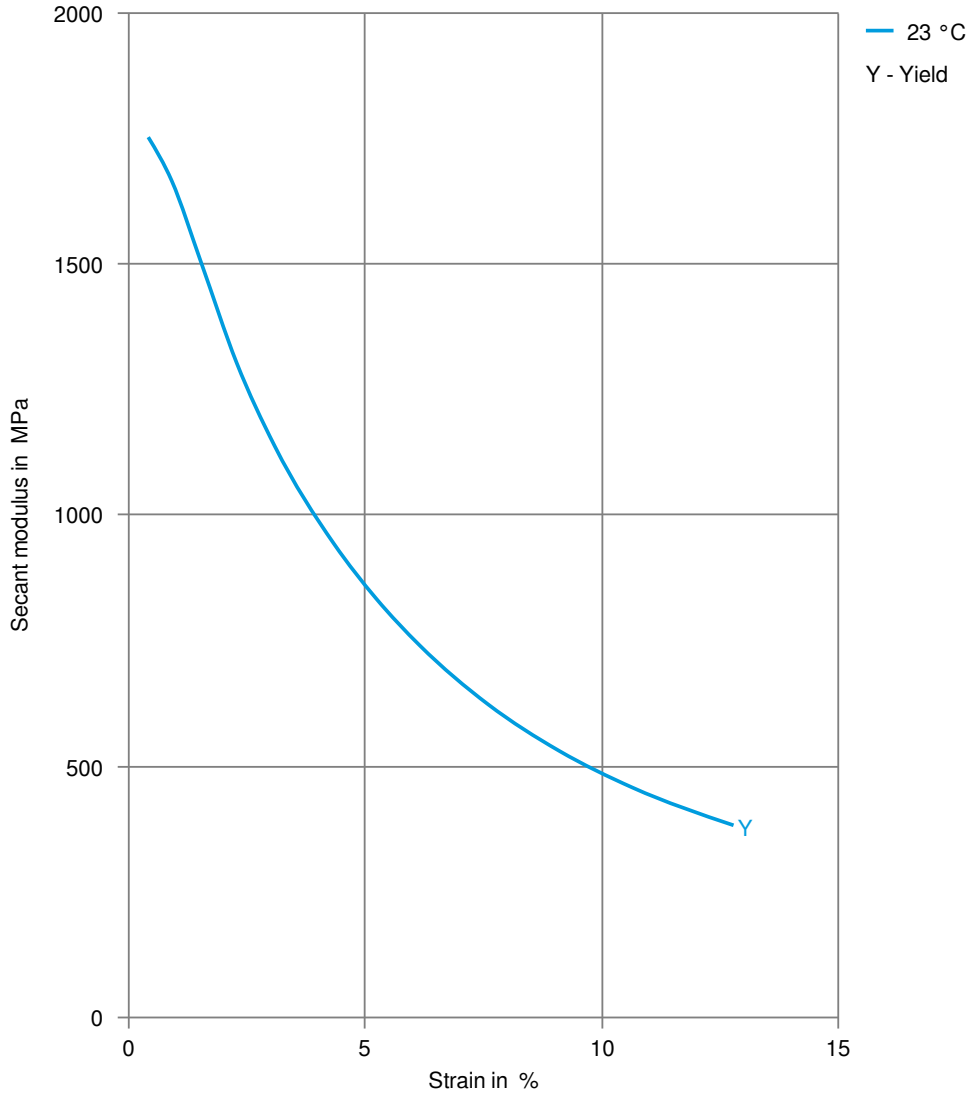
Secant modulus-strain



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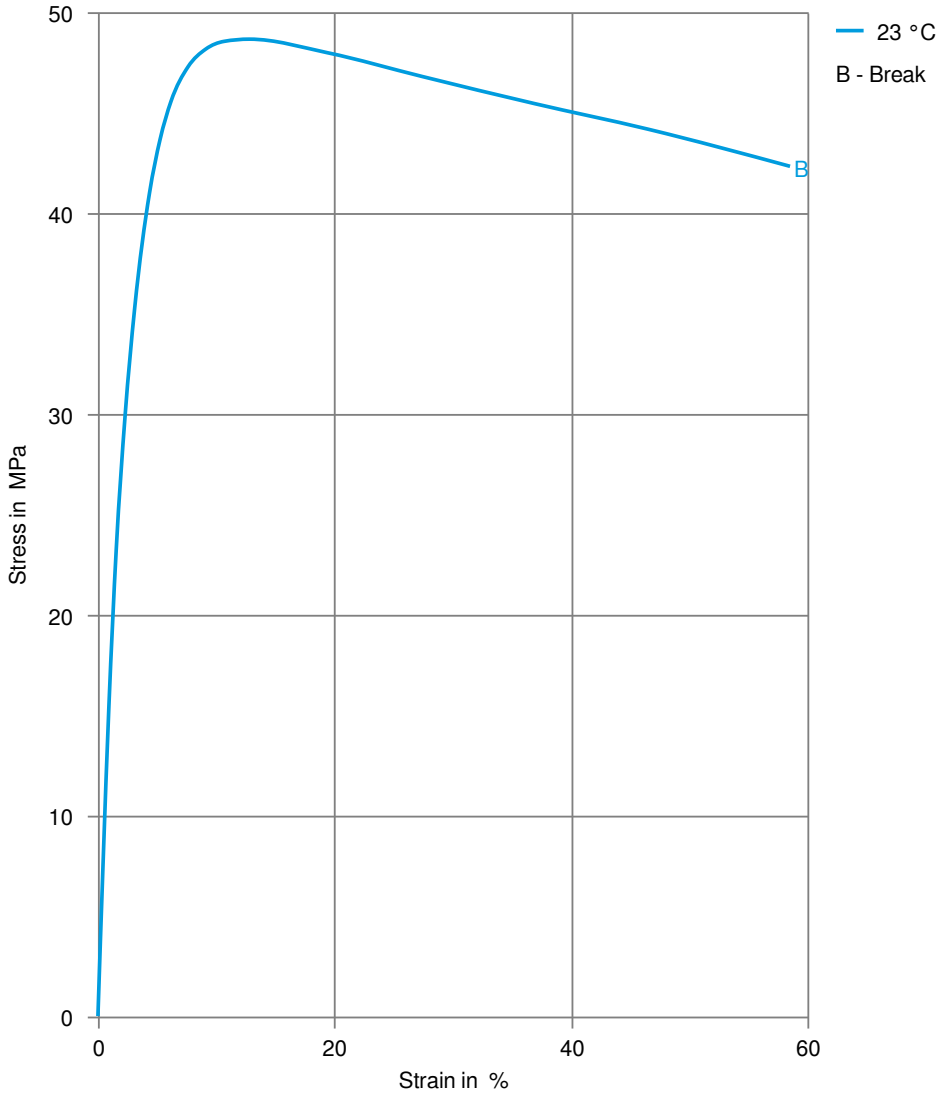
Stress-strain, 50mm/min



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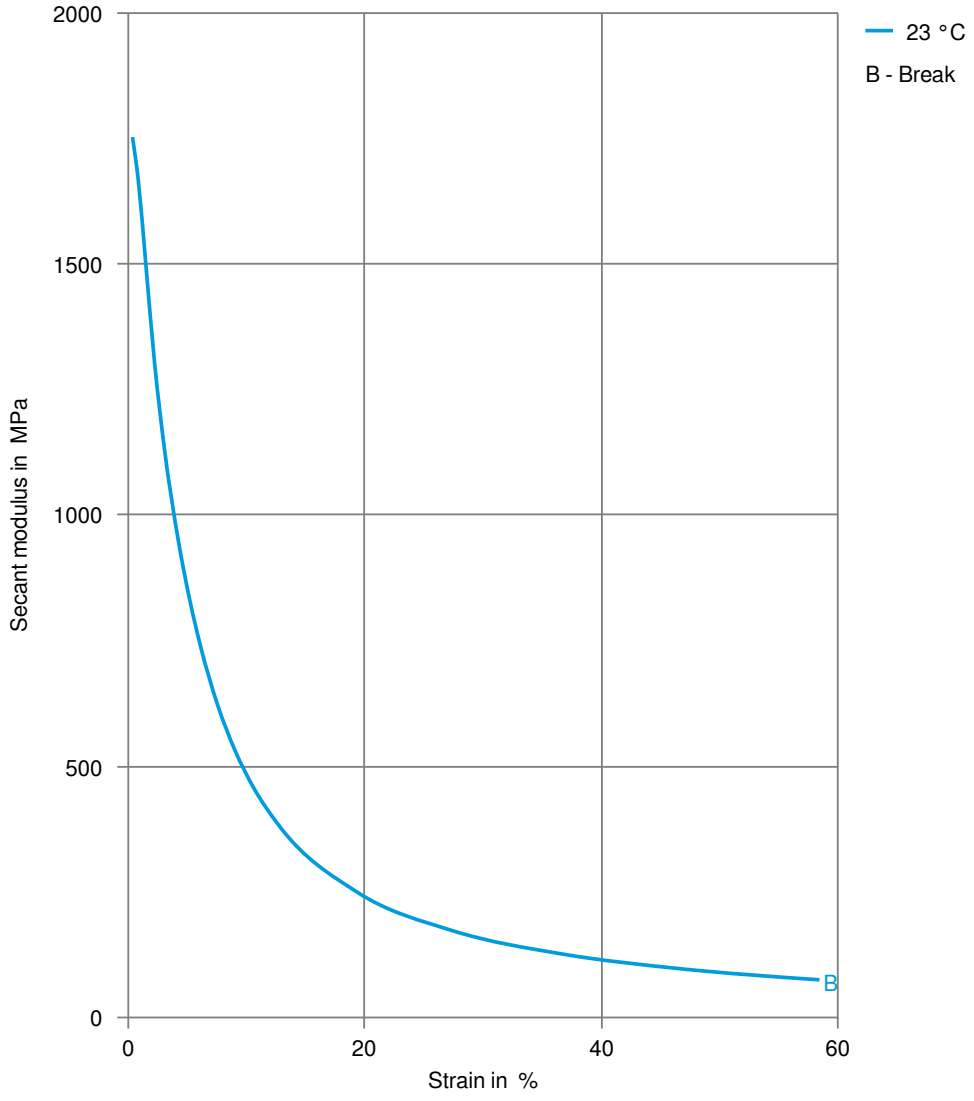
Secant modulus-strain, 50mm/min



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