# HOSTAFORM® TF-10XAP®

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

## 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 |
| Yield stress, 50mm/min | 49 | MPa | ISO 527-1/-2 |
| Yield strain, 50mm/min | 13 | % | ISO 527-1/-2 |
| Flexural Modulus | 1700 | MPa | ISO 178 |
| Flexural Stress at 3.5% | 46 | MPa | ISO 178 |
| Shear Modulus | 659 | MPa | ISO 6721 |
| Charpy notched impact strength, 23°C | 10 | $kJ/m^2$ | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 7 | $kJ/m^2$ | ISO 179/1eA |
| Hardness, Rockwell, M-scale | 65 | | ISO 2039-2 |

## Thermal properties

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

## Other properties

| | | | |
|---|---|---|---|
| Density | 1380 | $kg/m^3$ | ISO 1183 |

## Injection

| | | | |
|---|---|---|---|
| Drying Temperature | 100 - 120 | °C | |
| Drying Time, Dehumidified Dryer | 3 - 4 | h | |
| Melt Temperature Optimum | 190 | °C | Internal |
| Max. mould temperature | 80 - 100 | °C | |
| Back pressure | 2 | MPa | |
| Injection speed | slow-medium | | |

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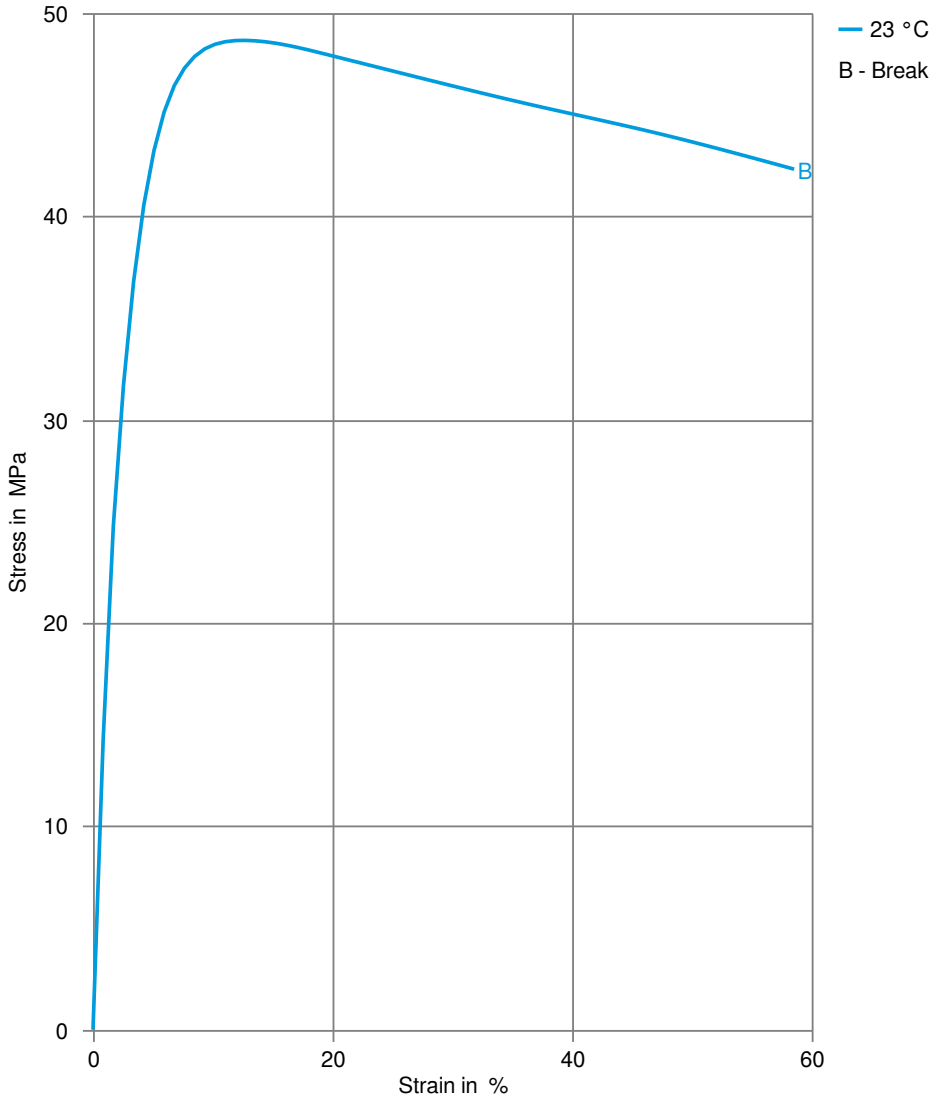
## Stress-strain



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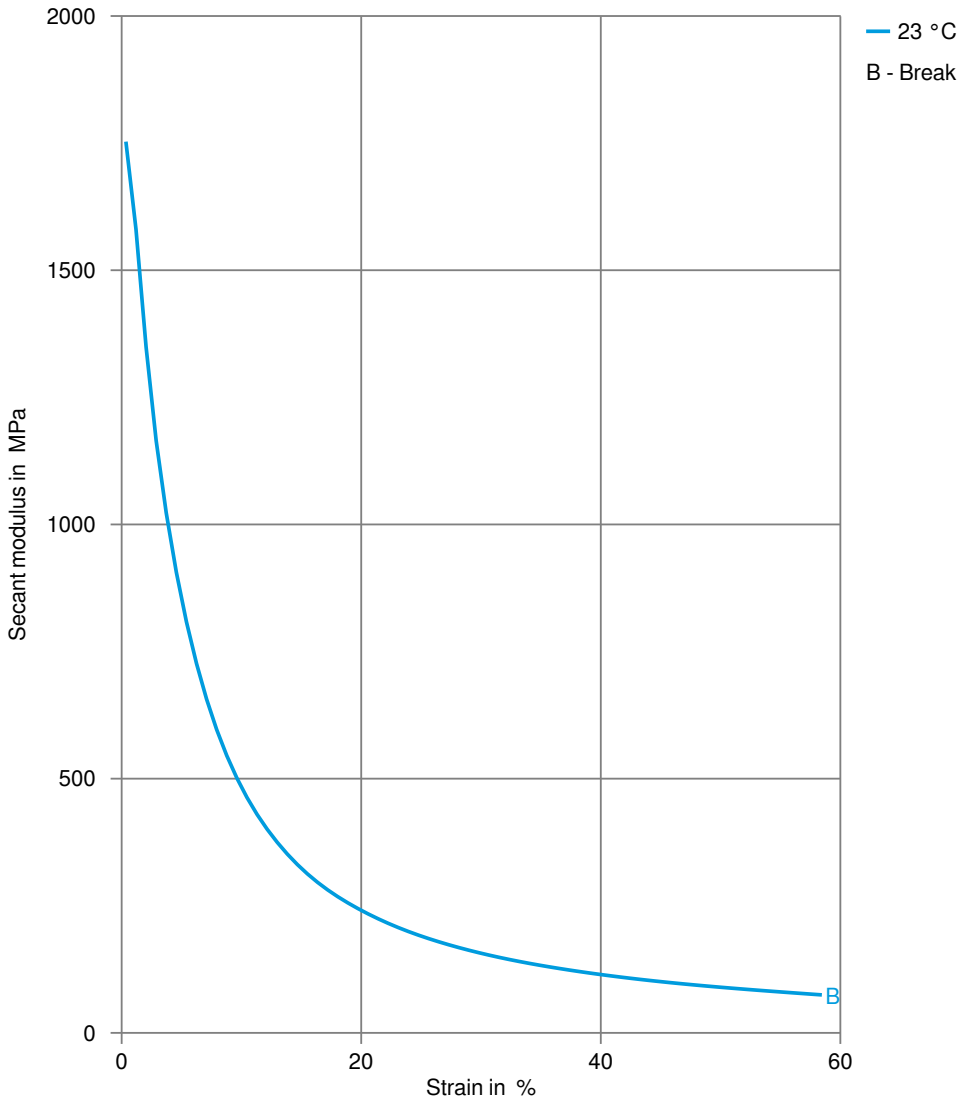
## Secant modulus-strain



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## Processing Texts

| | |
|---|---|
| Pre-drying | Drying is recommended. |



Revised: 2023-02-23 Source: Celanese Materials Database