

# 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 <sup>3</sup> /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 <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	7 kJ/m <sup>2</sup>	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

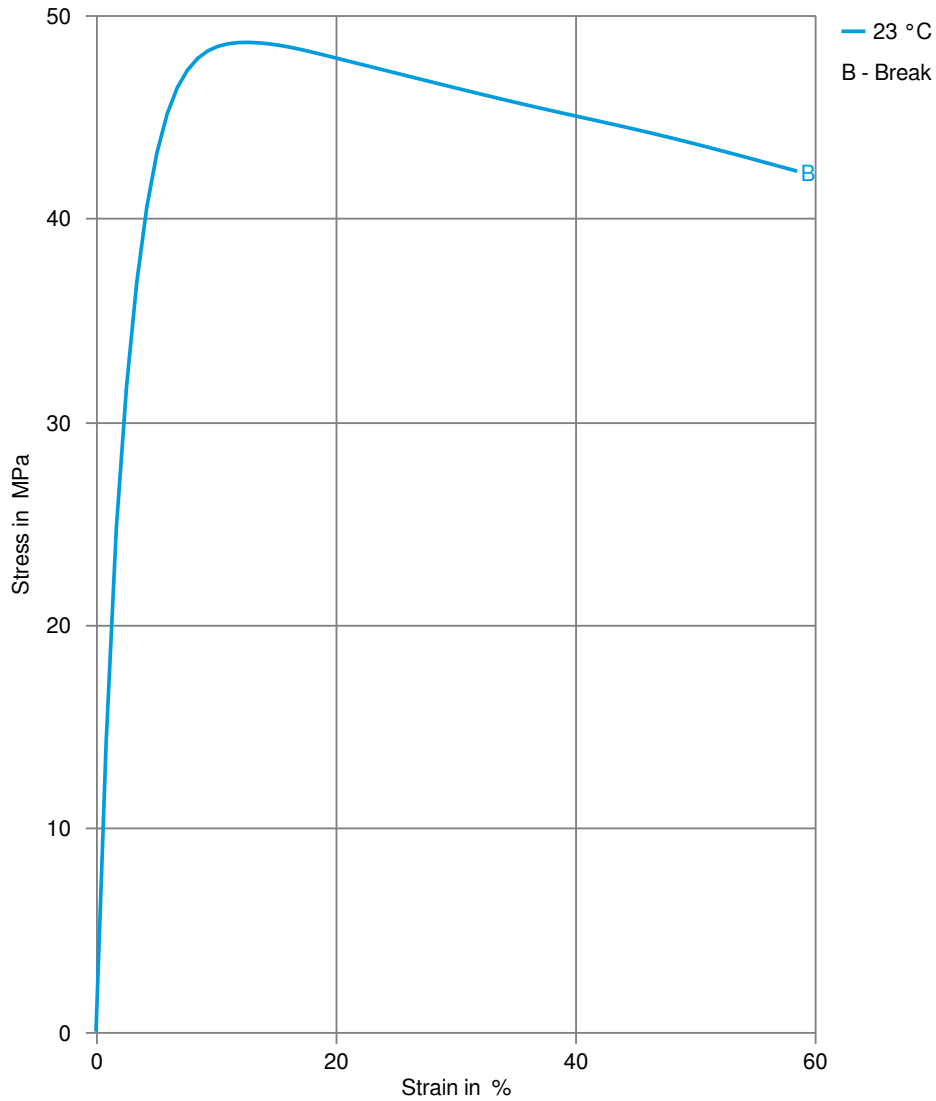
Density	1380 kg/m <sup>3</sup>	ISO 1183
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## Injection

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	

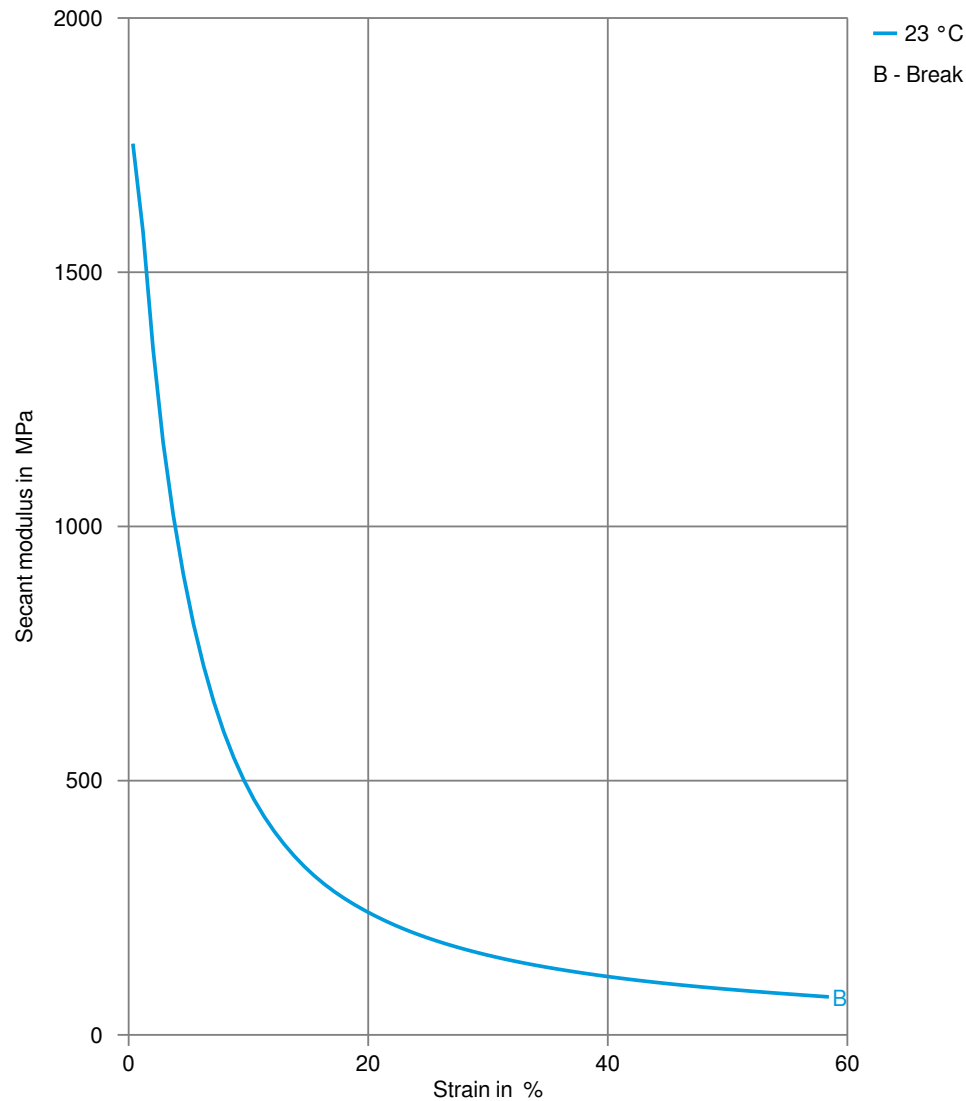
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## Stress-strain



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## Secant modulus-strain



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## Processing Texts

Pre-drying

Drying is recommended.

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