

Hostaform® TF-10XAP®

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer TF-10 XAP® is 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.

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Low volatilization		
	Good liquidity		
	General		
Uses	General		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	13.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.9	%	ISO 294-4
Flow direction	2.1	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1750	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	49.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	13	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1700	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.0	kJ/m ²	ISO 179/1eA
23°C	10	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	139	°C	ISO 75-2/B
1.8 MPa, not annealed	75.0	°C	ISO 75-2/A
Melting Temperature ¹	165	°C	ISO 11357-3
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	80.0 - 100	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Manifold Temperature: 190 to 200°C Zone 4 Temperature: 180 to 200°C

NOTE

1. 10°C/min

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