

HOSTAFORM® TF-10XAP® | POM | Impact Modified

Description

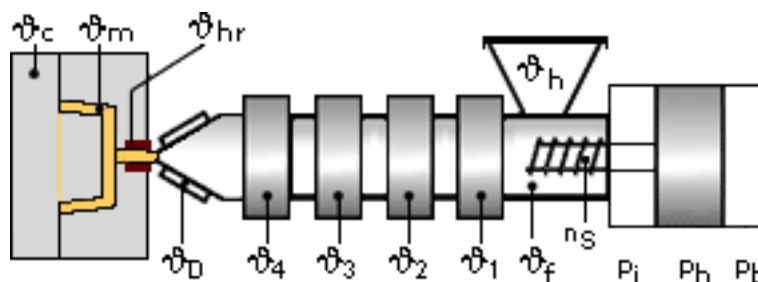
Hostaform® acetal copolymer TF-10 XAP® is low emission, improved flow, impact modified grade providing optimum performance in general purpose injection molding primarily for the interior automotive market. This grade provides overall excellent performance with improved impact in many applications.

Physical properties	Value	Unit	Test Standard
Density	1380	kg/m ³	ISO 1183
Melt volume rate (MVR)	13	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	2.1	%	ISO 294-4
Mold shrinkage - normal	1.9	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	1750	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	49	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	13	%	ISO 527-2/1A
Flexural modulus (23°C)	1700	MPa	ISO 178
Charpy notched impact strength @ 23°C	10.0	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	7.0	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	165	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	75	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	139	°C	ISO 75-1/-2

Typical injection moulding processing conditions



Pre Drying:

Drying is recommended.

Drying time: 3 h

Drying temperature: 80 - 100 °C

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Temperature:

	↻Manifold	↻Mold	↻Melt	↻Nozzle	↻Zone4	↻Zone3	↻Zone2	↻Zone1
min (°C)	190	80	180	180	180	180	180	170
max (°C)	200	100	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-medium

Special Info:

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

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General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

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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We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

The products mentioned herein are not intended for use in medical or dental implants.

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