Hostaform® TF-10XAP®

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product 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.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• General Purpose • Good Flow	• Good Impact Resistance • Impact Modified	• Low Emissions
Uses	• Automotive Applications	• Automotive Interior Parts	• General Purpose
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	13	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.9	%	
Flow	2.1	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	254000	psi	ISO 527-2/1A
Tensile Stress (Yield)	7110	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	13	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	247000	psi	ISO 178
Flexural Stress (3.5% Strain)	6670	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.3	ft·lb/in²	
73°F	4.8	ft·lb/in²	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	65		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (66 psi, Unannealed)	282	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	167	°F	ISO 75-2/A
Melting Temperature [2]	329	°F	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	338 to 356	°F

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Injection	Nominal Value	Unit
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	356 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 212	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 290	psi

Injection Notes

Zone4 temperature: 180 to 200°C

Hot runner temperature: 190 to 200°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 10°C/min