CELCON® M25

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Celcon® acetal copolymer grade M25 is a high molecular weight, higher toughness and impact resistance grade primarily used for extrusion and selected injection molding applications.
Chemical abbreviation according to ISO 1043-1: POM
Please also see Hostaform® C 2521.

产品信息

树脂鉴别	POM		ISO 1043
制品标识码	>POM<		ISO 11469

流变性能

熔体体积流动速度	2.2	cm^3/10min	ISO 1133
温度	190	°C	
负荷	2.16	kg	
模塑收缩率, 平行	2.2	%	ISO 294-4, 2577
模塑收缩率, 垂直	1.8	%	ISO 294-4, 2577

机械性能

拉伸模量	2460	MPa	ISO 527-1/-2
拉伸屈服应力, 50mm/min	62	MPa	ISO 527-1/-2
屈服伸长率, 50mm/min	13	%	ISO 527-1/-2
弯曲模量	2430	MPa	ISO 178
3.5%应变时的弯曲应力	68	MPa	ISO 178
断裂弯曲应变	3.5	%	ISO 178
1%形变时的压缩应力	31	MPa	ISO 604
拉伸蠕变模量, 1h	2100	MPa	ISO 899-1
拉伸蠕变模量, 1000h	1100	MPa	ISO 899-1
简支梁无缺口冲击强度, 23°C	250[P]	kJ/m^2	ISO 179/1eU
简支梁无缺口冲击强度, -30°C	190	kJ/m^2	ISO 179/1eU
简支梁缺口冲击强度, 23°C	9.1	kJ/m^2	ISO 179/1eA
悬臂梁缺口冲击强度, 23°C	8.3	kJ/m^2	ISO 180/1A
悬臂梁缺口冲击强度, -30°C	6.0	kJ/m^2	ISO 180/1A
悬臂梁无缺口冲击强度, 23°C	133	kJ/m^2	ISO 180/1U
悬臂梁无缺口冲击强度, -40°C	6.41	kJ/m^2	ISO 180/1U
洛氏硬度, M	82		ISO 2039-2

[P]: Partial Break

热性能

熔融温度, 10°C/min	166	°C	ISO 11357-1/-3
热变形温度, 1.8 MPa	94	°C	ISO 75-1/-2
热变形温度, 0.45 MPa	150	°C	ISO 75-1/-2
线性热膨胀系数, 平行	120	E-6/K	ISO 11359-1/-2
线性热膨胀系数, 垂直	120	E-6/K	ISO 11359-1/-2
熔体导热系数	0.155	W/(m K)	ISO 22007-2
熔体比热容	2210	J/(kg K)	ISO 22007-4

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阻燃性能

氧指数	14.9	%	ISO 4589-1/-2

电性能

表面电阻率	1.3E16	Ohm	IEC 62631-3-2
耐电弧性	240	s	UL 746B

其它性能

吸湿率, 2mm	0.2	%	类似ISO 62
吸水率, 2mm	0.75	%	类似ISO 62
吸水率, 浸泡 24小时	0.2	%	类似ISO 62
密度	1410	kg/m^3	ISO 1183

注塑

建议干燥	否	
干燥温度	100	°C
干燥时间，除湿干燥机	3 - 4	h
加工前水分含量	≤ 0.2	%
最优熔体温度	185	°C
最低熔体温度***	180	°C
最高熔体温度	190	°C
螺杆最大切线速度	≤ 0.3	m/s
最优模具温度	100	°C
最低模具温度	80	°C
最高模具温度	120	°C
保压范围	60 - 120	MPa
保压时间 (h表示部件的最大壁厚mm)	$2h^2$-3	s
背压	4	MPa
顶出温度	130	°C

汽车

OEM	STANDARD	ADDITIONAL INFORMATION
Continental	TST N 055 54.07	
Ford	WSK-M4D635-A1	Natural & Black
General Motors	GMW22P-POM-C1	Black
Li Auto	Q/LiA5310020	2021 (V2)
Nissan	POM-IC1-1	
Stellantis - Chrysler	MS.50095 / CPN-1986	Black
Stellantis - Chrysler	MS.50095 / CPN-4240	Natural

特性

加工方法	注塑, 薄膜挤出成型, 异型材挤出成型, 片材挤出成型, 其它挤出成型, 吹塑, 压延成型, 模压成型
添加剂	脱模助剂

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特殊性能	高粘度

其他信息

注塑

Preprocessing

Drying is generally not required because Celcon® and Hostaform® acetal copolymers are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can lead to splay (silver streaking) in molded parts. For better uniformity in molding especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 80 C (180 F) for 3hours. Desiccant hopper dryers are not required. Maximum water content = 0.35%

Processing

Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (I.E. general purpose 2:1 compression ratio) can result in unmelted particles and poor melt homogeneity. Using a high back pressure to make up for a low compression ratio may lead to excessive shear heating and deterioration of the material.

Melt Temperature: Preferred range 182-199 C (360-390 F). Melt temperature should never exceed 230 C (450 F).

Mold Surface Temperature: Preferred range 82-93 C (180-200 F) especially with wall thickness less than 1.5 mm (0.060 in.). May require mold temperature as high as 120 C (250 F) to reproduce mold surface or to assure minimal molded in stress. Wall thickness greater than 3mm (1/8 in.) may use a cooler (65 C/150 F) mold surface temperature and wall thickness over 6mm (1/4 in.) may use a cold mold surface down to 25 C (80 F). In general, mold surface temperatures lower than 82 C (180 F) may hinder weld line formation and produce a hazy surface or a surface with flow lines, pits and other included defects that can hinder part performance.

Postprocessing

Postprocessing conditioning and moisturizing are not required. It may be necessary to fixture large or complicated parts with varying wall thickness to prevent warpage while cooling to ambient temperature.

薄膜挤出成型

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can cause surface defects on the extruded film. For better uniformity especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 3 Hrs. at 80 C (180 F). Desiccant hopper dryers are not required. Max. moisture content = 0.35%.

Processing

Standard extruders with a length to diameter ratio of at least 20:1 are recommended. The screw should be a high compression ratio of at least 3:1 and preferably 4:1 to assure good melting and melt homogeneity. The design should be approximately 35% each for feed and metering sections with the remaining 30% as the transition zone.

Melt temperature: 160-220 C (320-430 F)

Postprocessing

Postprocessing conditioning or moisturizing is not required.

其他挤出成型

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can cause surface defects. For better uniformity especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying is 3 hours at 80 C (180 F). Desiccant hopper dryers are not required. Max. moisture content = 0.35%

Processing

Standard extruders with a length to diameter ratio of at least 20:1 are recommended. The screw should be a high compression ratio of at least 3:1 and preferably 4:1 to assure good melting and uniform melt homogeneity. The design should be approximately 35% each for the feed and metering sections with the remaining 30% as transition zone.

Melt temperature 180-220 C (355-430F)

Postprocessing

Postprocessing conditioning or moisturizing are not required. For thick walled sections (>3mm or 1/8 in.), annealing is recommended to reduce internal stresses.

Annealing temperature: 130-140 C (265-285 F)

Annealing time: 10 min/mm thickness

型材挤出成型

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can cause surface defects on the extrusion. For better uniformity especially when

using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 3 Hrs. at 80 C (180 F). Desiccant hopper dryers are not required. Max. moisture content = 0.035%.

Processing

Standard extruders with a length to diameter ratio of at least 20:1 are recommended. The screw should be a high compression ratio of at least 3:1 and preferably 4:1 to assure good melting and melt homogeneity. The design should be approximately 35% each for feed and metering sections with the remaining 30% as the transition zone.

Melt temperature: 180-220 C (360-430 F).

Postprocessing

Postprocessing or moisturizing is not required. For thick walled extrusions (>3 mm or 1/8 in.), annealing is recommended to reduce internal stresses.

Annealing temperature: 130-140 C (265-285 F)
Annealing time: 10 min/mm thickness

板材挤出成型

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can lead to surface defects. For better uniformity in sheet extrusion especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying is 3 hours at 80 C (180 F). Desiccant hopper dryers are not required. Max. water content = 0.35%.

Processing

Standard extruders with a length to diameter ratio of at least 20:1 are recommended. The screw should be a high compression ratio (at least 3:1 and preferably 4:1) to assure good melting and uniform melt homogeneity. The screw design should be approximately 35% each for the feed and metering sections with the remaining 30% as the transition zone.

Melt temperature 180-190 C (355-375 F).

Postprocessing

Postprocessing conditioning or moisturizing is not required. For thick walled sections (>3mm or 1/8 in.), annealing is recommended to reduce internal stresses.

Annealing temperature: 130-140 C (265-285 F)

Annealing time: 10 min/mm wall thickness

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吹塑

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Preprocessing

Consult product information services.

Processing

Consult product information services.

Postprocessing

Consult product information services.

压延成型

Preprocessing

Consult product information services.

Processing

Consult product information services.

Postprocessing

Consult product information services.

模压成型

Preprocessing

Consult product information services.

Processing

Consult product information services.

Postprocessing

Consult product information services.

加工注意事项

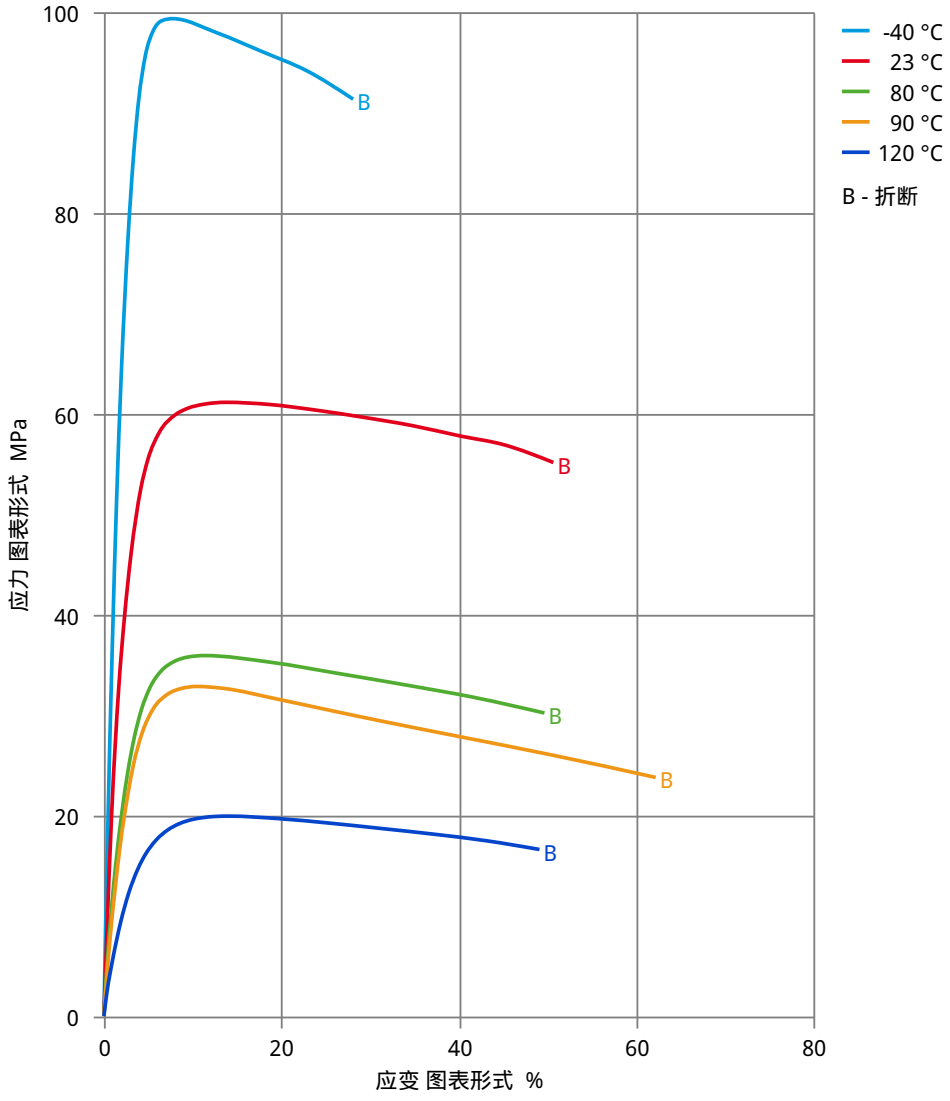
Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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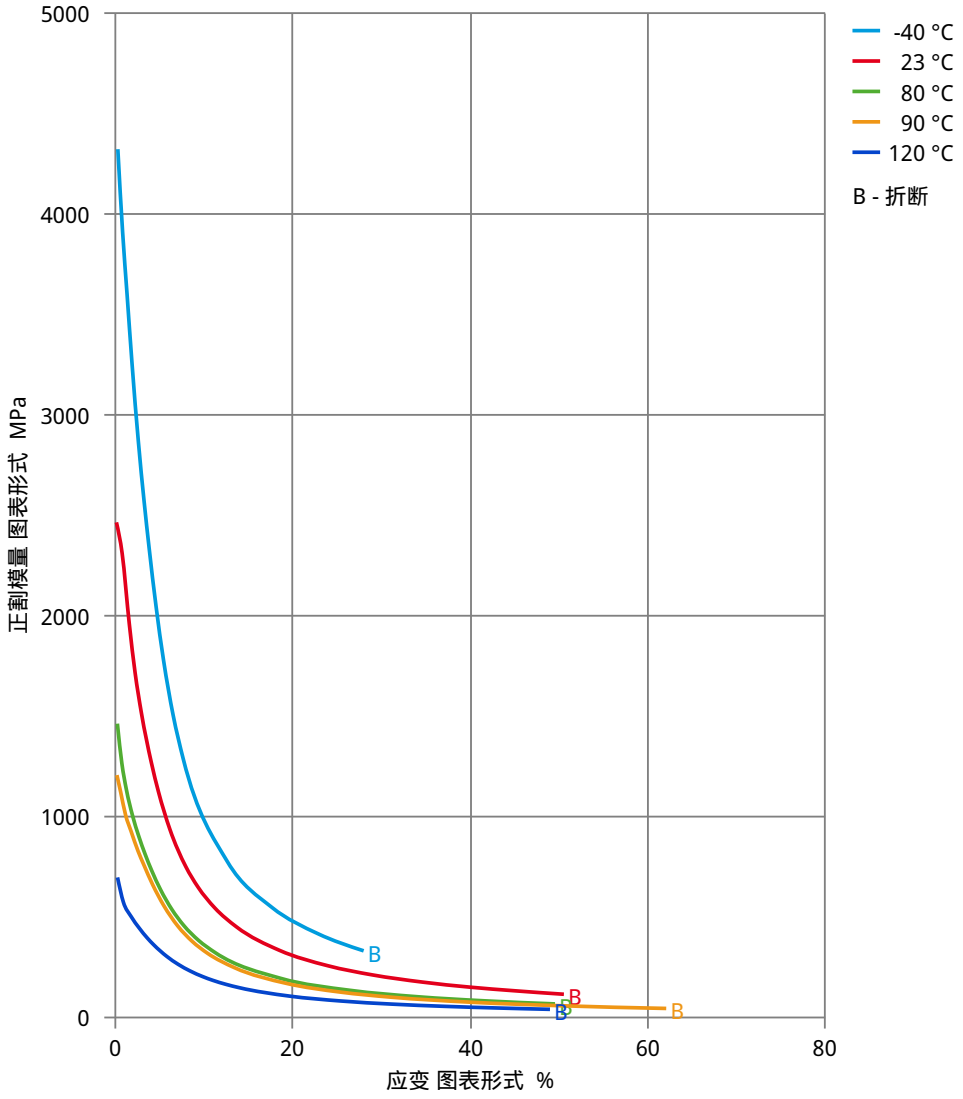
应力 - 应变



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正割模量 - 应变



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