Celanese
The chemistry inside innovation™

HOSTAFORM® C 2521 G

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Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 29988- POM-K, M-GNS, 01-001 POM copolymer Stiff-flowing type for injection molding and extrusion, modified with (R) GUR (PE-UHMW); good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation; very good lubricating properties. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm. Ranges of applications: For injection molding parts and semi-finished products with higher requirements on lubricating properties. FMVSS = Federal Motor Vehicle Safety Standard (USA)

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	1.5	cm^3/10min	ISO 1133
温度	190	°C	
负荷	2.16	kg	

机械性能

拉伸模量	2100	MPa	ISO 527-1/-2
拉伸屈服应力, 50mm/min	44	MPa	ISO 527-1/-2
屈服伸长率, 50mm/min	12	%	ISO 527-1/-2
断裂标称应变	15	%	ISO 527-1/-2
弯曲模量	2000	MPa	ISO 178
拉伸蠕变模量, 1h	1800	MPa	ISO 899-1
拉伸蠕变模量, 1000h	1000	MPa	ISO 899-1
简支梁无缺口冲击强度, 23°C	50	kJ/m^2	ISO 179/1eU
简支梁无缺口冲击强度, -30°C	50	kJ/m^2	ISO 179/1eU
简支梁缺口冲击强度, 23°C	5	kJ/m^2	ISO 179/1eA
简支梁缺口冲击强度, -30°C	4.5	kJ/m^2	ISO 179/1eA
球压痕硬度, H 358/30	110	MPa	ISO 2039-1

热性能

熔融温度, 10°C/min	165	°C	ISO 11357-1/-3
热变形温度, 1.8 MPa	84	°C	ISO 75-1/-2
线性热膨胀系数, 平行	100	E-6/K	ISO 11359-1/-2

电性能

相对介电常数, 100Hz	3.8		IEC 62631-2-1
相对介电常数, 1MHz	3.8		IEC 62631-2-1
介质损耗因子, 100Hz	20	E-4	IEC 62631-2-1
介质损耗因子, 1MHz	70	E-4	IEC 62631-2-1
体积电阻率	1E12	Ohm.m	IEC 62631-3-1
表面电阻率	1E14	Ohm	IEC 62631-3-2
介电强度	35	kV/mm	IEC 60243-1
相对漏电起痕指数	600		IEC 60112

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其它性能

吸湿率, 2mm	0.2	%	类似ISO 62
吸水率, 2mm	0.8	%	类似ISO 62
密度	1340	kg/m³	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	200	°C
最低熔体温度***	190	°C
最高熔体温度	210	°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)	2h²-3	s
背压	2	MPa

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
添加剂	脱模助剂
特殊性能	高粘度, 低磨损/低摩擦

其他信息

注塑

Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Processing

Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Postprocessing

Conditioning e.g. moisturizing is not necessary.

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薄膜挤出成型

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Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Processing

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

其他挤出成型

Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Processing

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

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Postprocessing

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Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

型材挤出成型

Preprocessing

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Max. Water content 0,2 %

Processing

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Melt temperature 180-190 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

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Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

板材挤出成型

Preprocessing

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Max. Water content 0,2 %

Processing

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

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.

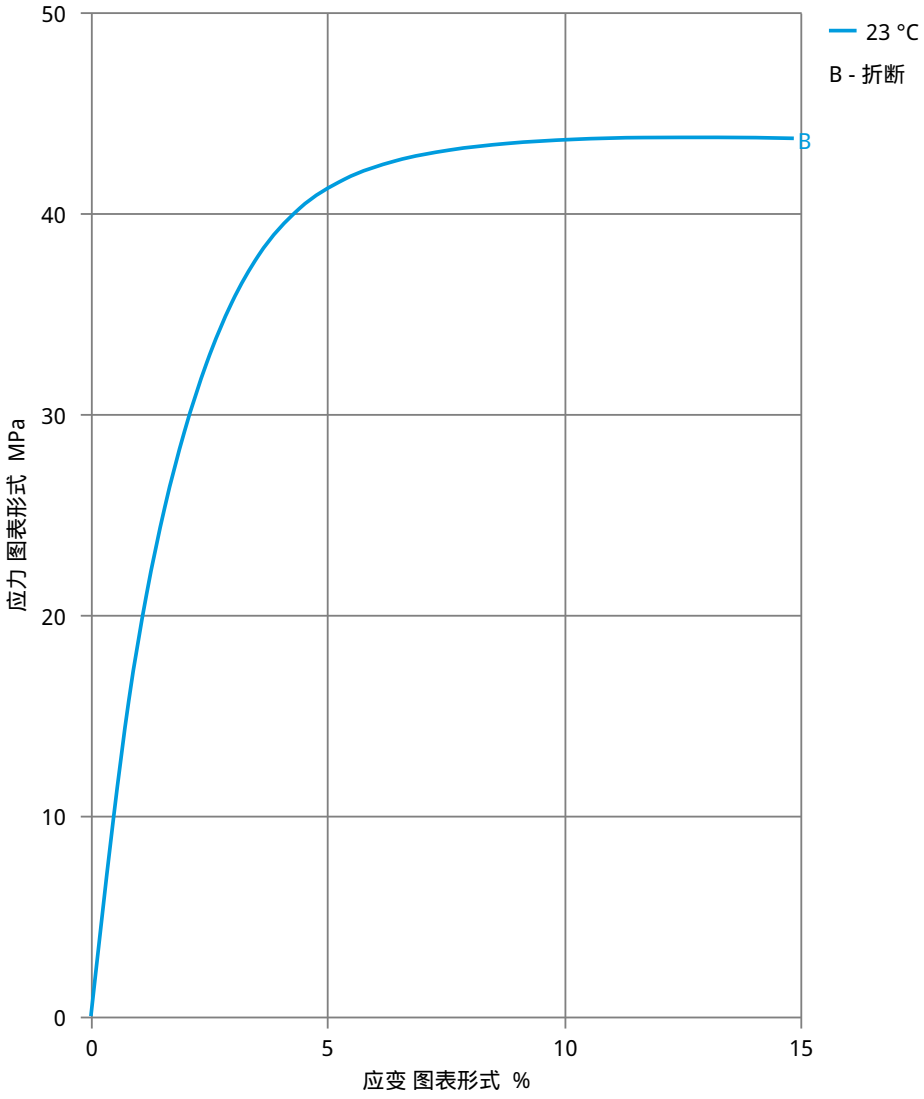
Storage

The product can then be stored in standard conditions until processed.

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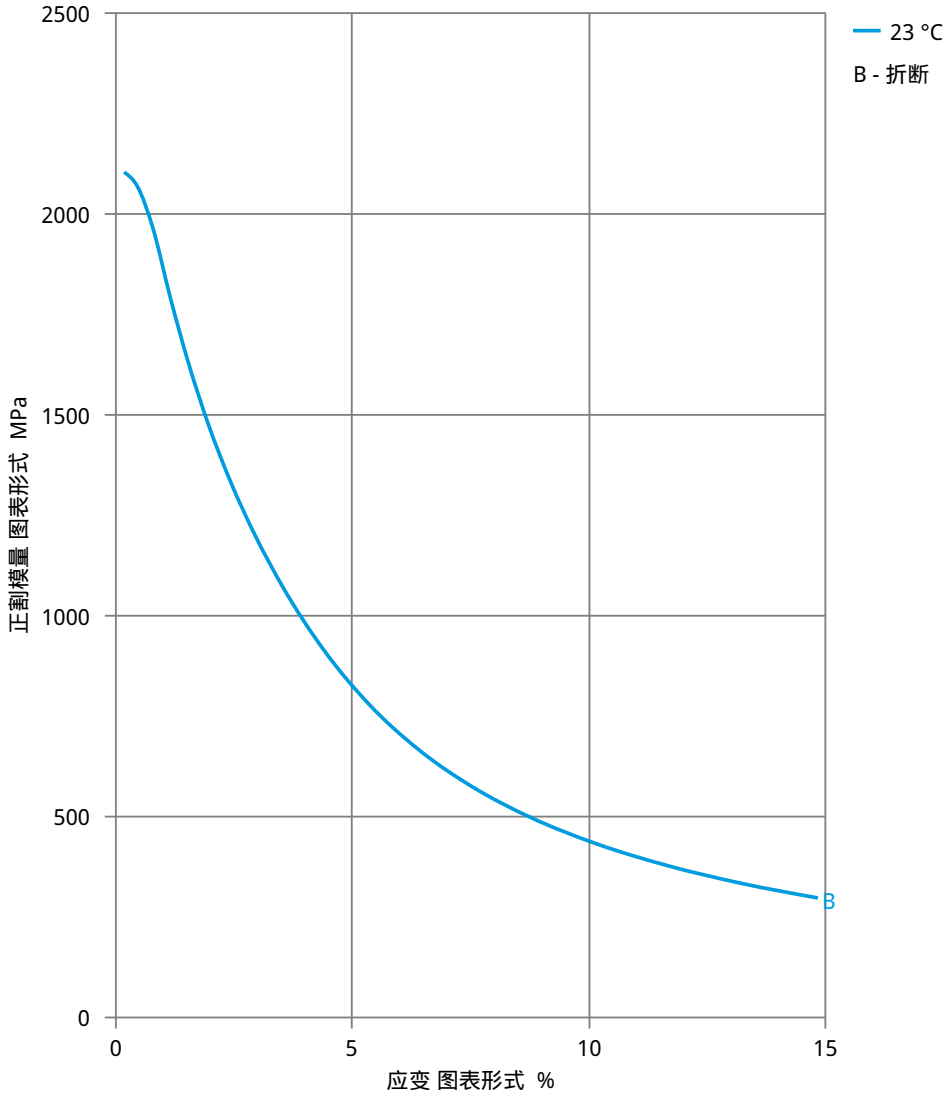
应力 - 应变



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正割模量 - 应变



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