Celanese
The chemistry inside innovation™

HOSTAFORM® C 9021 FC

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Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 29988- POM-K, M-GNR, 03-002 POM copolymer Injection molding type with high rigidity, hardness and toughness; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. The products are in compliance with EU regulations (EC) No 1935/2004, (EC) No 2023/2006 and (EU) 10/2011, USA FDA 21 CFR Titles 177.2470, and Chinese food contact regulations GB4806 and GB9685.

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	8	cm^3/10min	ISO 1133
温度	190	°C	
负荷	2.16	kg	
模塑收缩率范围, 平行	2	%	ISO 294-4, 2577
模塑收缩率范围, 垂直	1.9	%	ISO 294-4, 2577

机械性能

拉伸模量	2850	MPa	ISO 527-1/-2
拉伸屈服应力, 50mm/min	64	MPa	ISO 527-1/-2
屈服伸长率, 50mm/min	9	%	ISO 527-1/-2
断裂标称应变	30	%	ISO 527-1/-2
弯曲模量	2700	MPa	ISO 178
弯曲强度	89	MPa	ISO 178
简支梁无缺口冲击强度, 23°C	220	kJ/m^2	ISO 179/1eU
简支梁无缺口冲击强度, -30°C	220	kJ/m^2	ISO 179/1eU
简支梁缺口冲击强度, 23°C	6.5	kJ/m^2	ISO 179/1eA
简支梁缺口冲击强度, -30°C	6	kJ/m^2	ISO 179/1eA
泊松比	0.399		

热性能

熔融温度, 10°C/min	166	°C	ISO 11357-1/-3
热变形温度, 1.8 MPa	104	°C	ISO 75-1/-2
热变形温度, 0.45 MPa	160	°C	ISO 75-1/-2
线性热膨胀系数, 平行	110	E-6/K	ISO 11359-1/-2
线性热膨胀系数, 垂直	110	E-6/K	ISO 11359-1/-2
熔体导热系数	0.155	W/(m K)	ISO 22007-2
有效热扩散率, 顺流	4.85E-8	m^2/s	ISO 22007-4
熔体比热容	2210	J/(kg K)	ISO 22007-4

电性能

相对介电常数, 100Hz	4		IEC 62631-2-1
相对介电常数, 1MHz	4		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	50	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

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介电强度	35	kV/mm	IEC 60243-1
相对漏电起痕指数	600		IEC 60112

其它性能

吸湿率, 2mm	0.2	%	类似ISO 62
吸水率, 2mm	0.65	%	类似ISO 62
密度	1410	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	4	MPa
顶出温度	140	°C

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

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.

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Melt temperature 190-210 °C
Mould temperature 80-120 °C

Postprocessing

Conditioning e.g. moisturizing is not necessary.

薄膜挤出成型

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

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

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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

板材挤出成型

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

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

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加工注意事项

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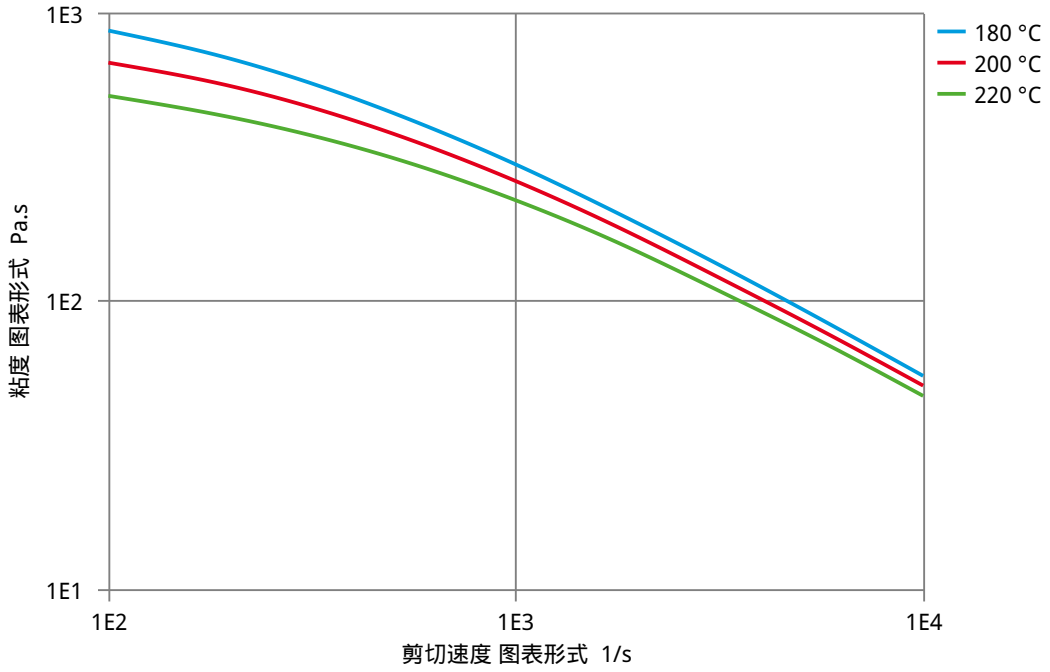
Pre-Drying

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.

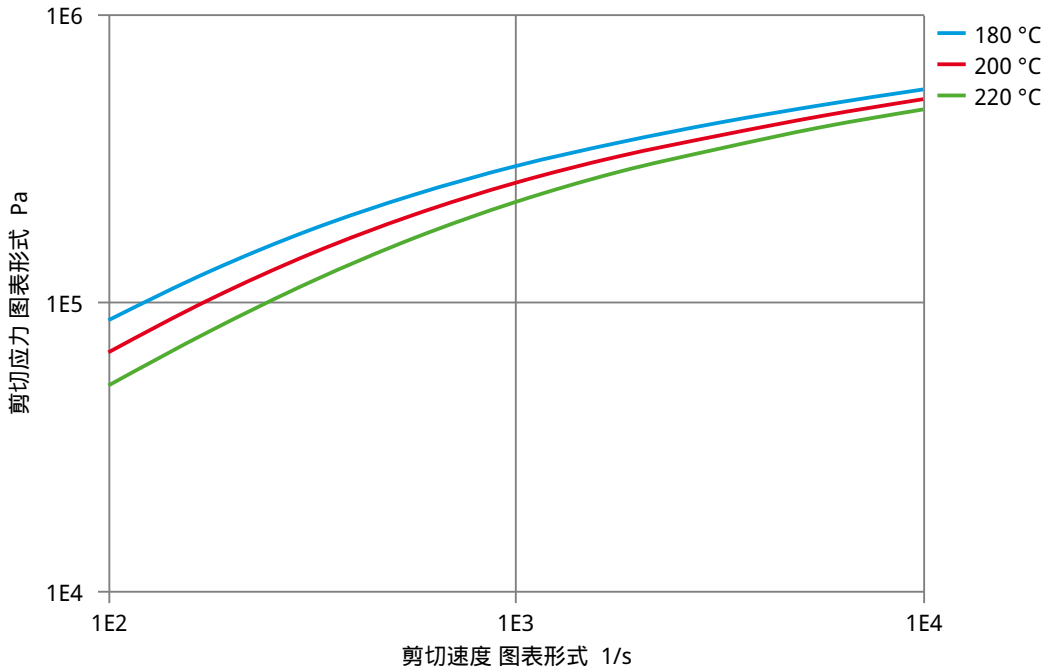
粘度 - 剪切速度



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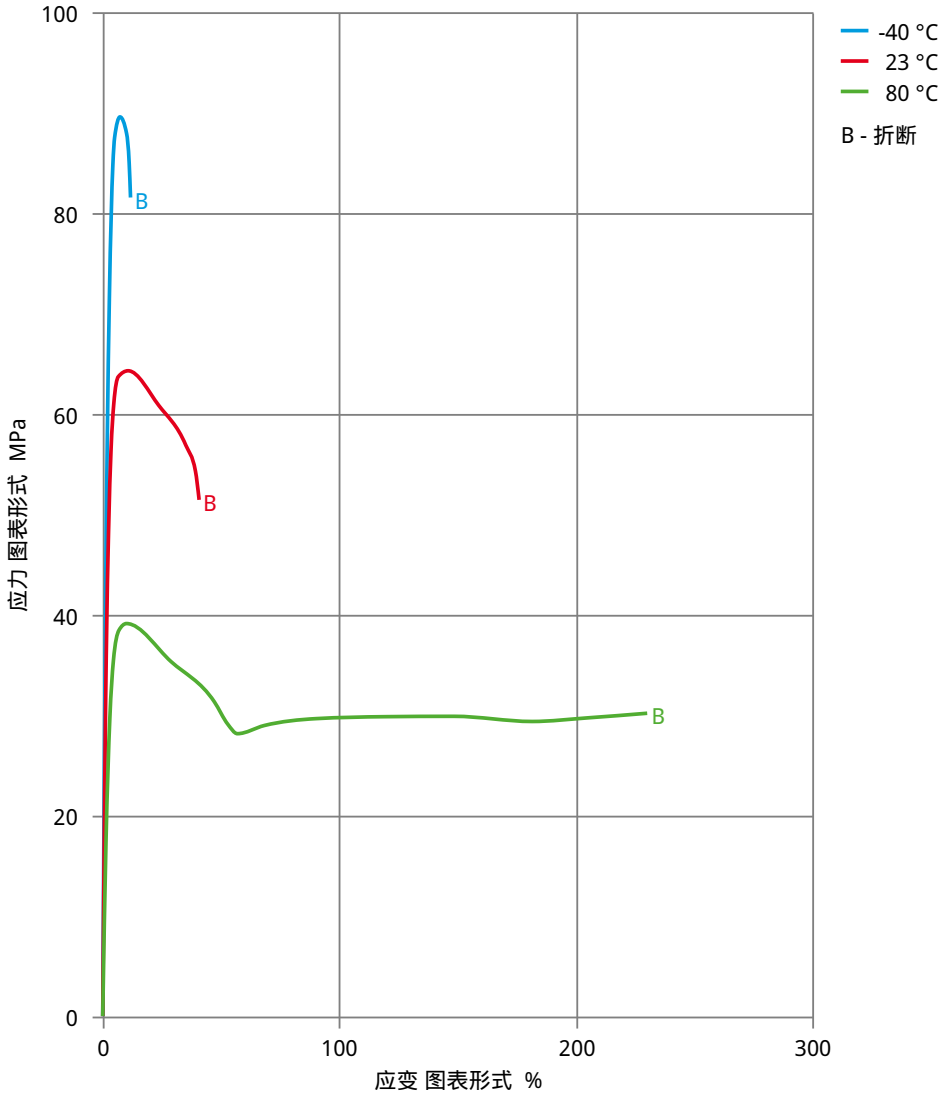
剪切应力 - 剪切速度



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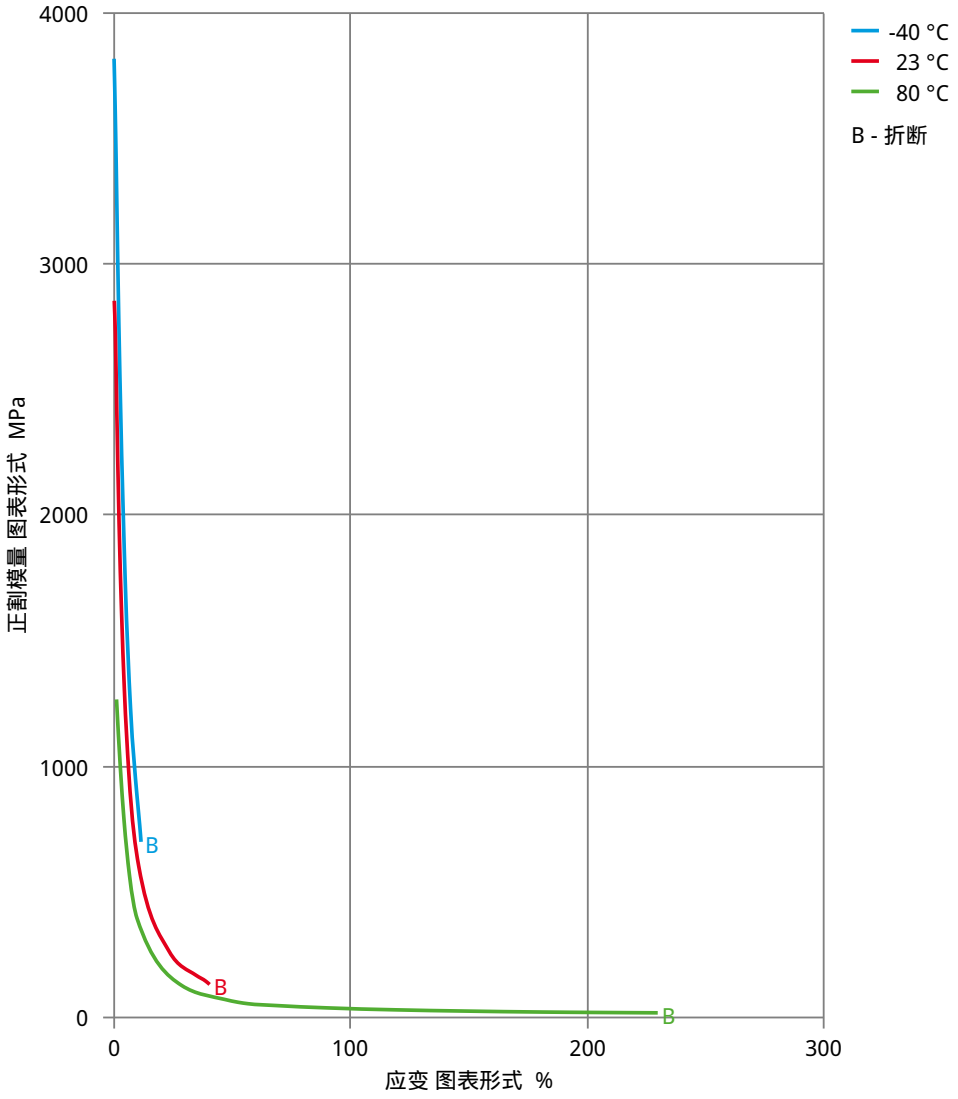
应力 - 应变



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正割模量 - 应变



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