Celanese
The chemistry inside innovation™

HOSTAFORM® RF2464

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Hostaform® POM RF2464 is an impact modified acetal copolymer that has been specially designed for Rotomolding. The material is UV stabilized and is available in natural or can be supplied in a pre-colored black. Hostaform® POM RF2464 has excellent toughness balanced with low fuel permeation and meets EPA and CARB regulations as a single layer solution in fuel tanks.

产品信息

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

流变性能

熔体质量流动速率	2.8	g/10min	ISO 1133
熔体质量流动速率，温度	190	°C	
熔体质量流动速率，负荷	2.16	kg	
模塑收缩率范围, 平行	1.5 - 3	%	ISO 294-4, 2577
模塑收缩率范围, 垂直	1.5 - 3	%	ISO 294-4, 2577

机械性能

拉伸模量	1420	MPa	ISO 527-1/-2
拉伸模量	1400	MPa	ASTM D 638
拉伸屈服应力, 50mm/min	40	MPa	ISO 527-1/-2
屈服伸长率, 50mm/min	40	%	ISO 527-1/-2
拉伸断裂应力, 50mm/min	31	MPa	ISO 527-1/-2
拉伸强度	40	MPa	ASTM D 638
断裂伸长率	56.7	%	ASTM D 638
断裂伸长率, 50mm/min	>50	%	ISO 527-1/-2
弯曲模量	1360	MPa	ISO 178
弯曲模量	1370	MPa	ASTM D 790
剪切强度	40	MPa	ASTM D 732
简支梁无缺口冲击强度, 23°C	N	kJ/m^2	ISO 179/1eU
简支梁缺口冲击强度, 23°C	15.5	kJ/m^2	ISO 179/1eA
简支梁缺口冲击强度, -40°C	8.5	kJ/m^2	ISO 179/1eA
多轴冲击, 总能量, 23°C	35	J	ASTM D 3763
多轴冲击, 最高负荷, 23°C	4000	N	ASTM D 3763
平均失效能, 23°C	23	J	ARM Impact Test
平均失效能, -20°C	13.5	J	ARM Impact Test
平均失效能, -40°C	9	J	ARM Impact Test

热性能

熔融温度, 10°C/min	165	°C	ISO 11357-1/-3
热变形温度, 0.45MPa	125	°C	ASTM D 648
热变形温度, 1.8MPa	67	°C	ASTM D 648

其它性能

密度	1330	kg/m^3	ISO 1183

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特性

加工方法	滚塑成型
特殊性能	抗冲改性, 光稳定

其他信息

旋转成型

Preprocessing

Typical Oven Times (440-520ºF (225ºC-270ºC) typical set temps. on gas ovens and aluminum tooling)
*Oven types, times and temperatures can vary.
*Outer wall material temperature should not exceed 450ºF/232ºC.
0.150” wall (3.8 mm) 15-20 minutes
0.200” wall (5.1mm) 18-35 minutes
Typical Air Cooling
Rotate in air 0*-20 minutes (5-10 min. recommended)
*Although some tooling configurations could allow 0min in air possible, it is not recommended to perform a quick cool down right out of the oven.
Rotate in forced air 10-30 minutes. Water cooling of tool may be used.
Ideal IAT (Internal Air Temperature)
375ºF (190ºC) 4-12 minutes (365ºF - 400ºF typical)
405ºF (207ºC) do not exceed
< 150ºF (93ºC) recommended demold temp.
Outer wall Temp.
410-450ºF (210-232ºC) Typical
450ºF (232ºC) do not exceed

Processing

Existing molds usually suitable (Typical mold shrink is 1.5-3%)
Standard Pulverizers (attrition mills) are suitable. Product available in powder. Pellets should be reduced to 35mesh.
ARM 2.1 Flowability and Bulk Density Funnels are suitable to test powder.
Mold Releases can cause surface blistering. Mold Release or special tool coatings typically not needed. Compatible with certain flow enhancing products. Consult a Celanese representative for recommendations.

Start with a clean, blasted and grained tooling surface. For parting lines, removing all remnants of previous materials used in the tooling. Allow 1 or 2 molding shots to remove blasting residue.
Typical 4:1 ratio Major/Minor axis rotational speed (8:2, 6:1.5, etc.)
Product exhibits good flow and seal around in-mold inserts.
Compatible with most secondary operations (In mold & post mold labelling,

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machining, assembly, etc). Flame treating not recommended.

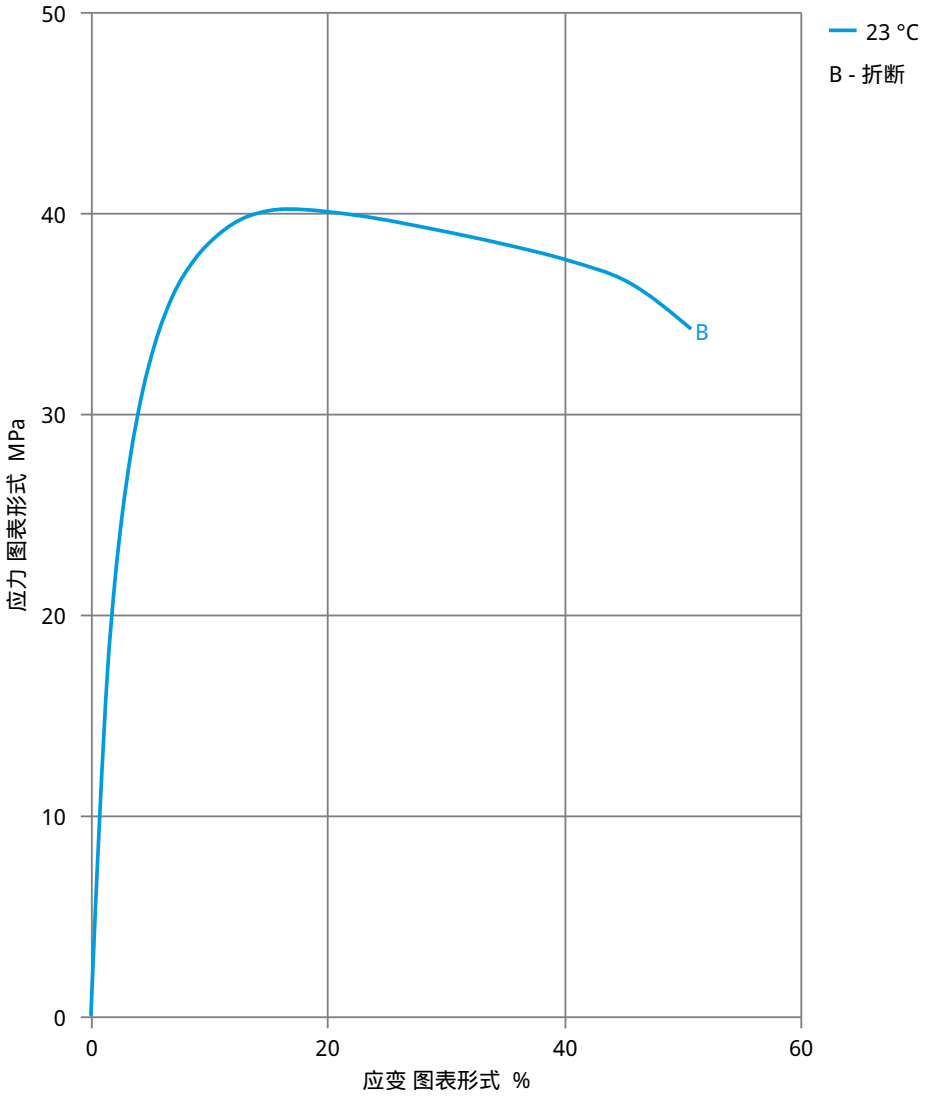
Ensure adequate ventilation at all stages of the process including demolding.

Following demold allow part to cool to room temperature and inside of part to fully vent and evacuate air and gasses before performing secondary processing or examinations.

Avoid inadvertant mixing with PVC even in trace amounts.

Do not perform oven or tool burn-outs to clean polymer from ovens or tools.

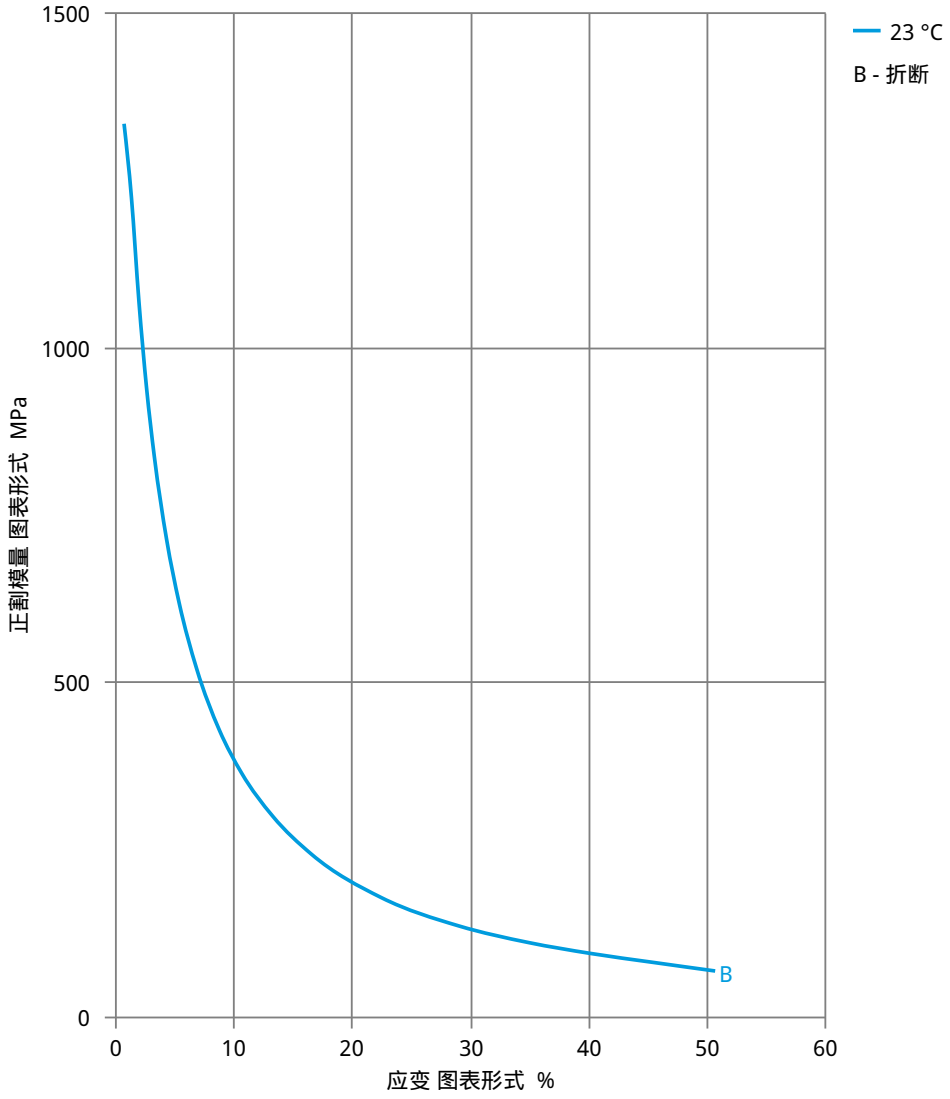
应力 - 应变



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正割模量 - 应变



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