

HOSTAFORM® C 9021 XAP®2 - POM

Beschreibung

POM-Copolymer Standard-Spritzgußtyp mit geringerer Emission, speziell für den Fahrzeuginnenraum. Brenngeschwindigkeit ISO 3795 und FMVSS 302 < 100 mm/min ab 1 mm Emissionen nach VDA 275 <2 mg/kg (natur) Emissionen nach VDA 275 <5 mg/kg (farbig)

Physikalische Eigenschaften	Wert	Einheit	Test Standard
Dichte	1410	kg/m³	ISO 1183
Schmelzevolumenrate, MVR	8	cm³/10min	ISO 1133
MVR temperatur	190	°C	ISO 1133
MVR belastung	2,16	kg	ISO 1133
Verarbeitungsschwindung, parallel	2,0	%	ISO 294-4, 2577
Verarbeitungsschwindung, senkrecht	1,9	%	ISO 294-4, 2577
Wasseraufnahme, 23 °C-Sätt	0,65	%	ISO 62
Feuchtigkeitsaufnahme, 23 °C/50%RH	0,2	%	ISO 62

Mechanische Eigenschaften	Wert	Einheit	Test Standard
Zug-Modul	2700	MPa	ISO 527-2/1A
Streckspannung, 50mm/min	64	MPa	ISO 527-2/1A
Streckdehnung, 50mm/min	10	%	ISO 527-2/1A
Nominelle Bruchdehnung, 50mm/min	35	%	ISO 527-2/1A
Zug-Kriechmodul, 1h	2400	MPa	ISO 899-1
Zug-Kriechmodul, 1000h	1200	MPa	ISO 899-1
Biegemodul, 23 °C	2600	MPa	ISO 178
Charpy-Schlagzähigkeit, +23 °C	220 ^[P]	kJ/m²	ISO 179/1eU
Charpy-Schlagzähigkeit, -30 °C	220	kJ/m²	ISO 179/1eU
Charpy-Kerbschlagzähigkeit, +23 °C	6,5	kJ/m²	ISO 179/1eA
Charpy-Kerbschlagzähigkeit, -30 °C	6	kJ/m²	ISO 179/1eA

P: Teilweiser Bruch

Thermische Eigenschaften	Wert	Einheit	Test Standard
Schmelztemperatur, 10 °C/min	166	°C	ISO 11357-1/-3
Formbeständigkeitstemperatur, 1.80 MPa	104	°C	ISO 75-1, -2
Formbeständigkeitstemperatur, 0.45 MPa	157	°C	ISO 75-1, -2
Vicat-Erweichungstemperatur, 50 °C/h 50N	150	°C	ISO 306
Längenausdehnungskoeffizient, parallel	1,2	E-4/°C	ISO 11359-2
Längenausdehnungskoeffizient, senkrecht	1,2	E-4/°C	ISO 11359-2

Elektrische Eigenschaften	Wert	Einheit	Test Standard
Dielektrizitätszahl, 100Hz	4	-	IEC 60250
Dielektrizitätszahl, 1MHz	4	-	IEC 60250
Dielektrischer Verlustfaktor, 100Hz	20	E-4	IEC 60250
Dielektrischer Verlustfaktor, 1MHz	50	E-4	IEC 60250
Spezifischer Durchgangswiderstand	1E12	Ohm*m	IEC 60093
Spezifischer Oberflächenwiderstand	1E14	Ohm	IEC 60093
Elektrische Durchschlagfestigkeit	35	kV/mm	IEC 60243-1
Vergleichszahl der Kriechwegbildung	600	-	IEC 60112

Typische Spritzgußbedingungen

Vortrocknung	Wert	Einheit	Test Standard
Max. zulässige Restfeuchte	0,15	%	-
Trocknungszeit	3 - 4	h	-
Trocknungstemperatur	100 - 120	°C	-
Verarbeitungstemperaturen	Wert	Einheit	Test Standard
Trichtertemperatur	20 - 30	°C	-
Temperatur in der Einzugszone	60 - 80	°C	-
Zone1 Temperatur	170 - 175	°C	-

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Zone2 Temperatur	180 - 185	°C	-
Zone3 Temperatur	180 - 195	°C	-
Zone4 Temperatur	180 - 200	°C	-
Düsentemperatur	190 - 200	°C	-
Masstemperatur	180 - 200	°C	-
Werkzeugtemperatur	80 - 120	°C	-
Heißkanaltemperatur	190 - 200	°C	-
Verarbeitungsdrücke	Wert	Einheit	Test Standard
Staudruck	40	bar	-
Verarbeitungsgeschwindigkeiten	Wert	Einheit	Test Standard
Einspritzgeschwindigkeit	slow-medium	-	-
Schneckendrehzahlen	Wert	Einheit	Test Standard
Schneckendrehzahl, 25mm	150	RPM	-
Schneckendrehzahl, 40mm	100	RPM	-
Schneckendrehzahl, 55mm	70	RPM	-

Weitere Informationen

Pre-drying

recommended

Spritzgießen

Auf handelsüblichen Spritzgießmaschinen mit 15-25 D langen Dreizonen-Schnecken verarbeitbar.

Merkmale

Produktkategorien	Lieferformen
Ungefüllt	Granulat
Verarbeitungsmethoden	Additive
Spritzgießen	Entformungshilfsmittel

Kontakt

Americas

8040 Dixie Highway
Florence, KY 41042 USA
Product Information Service
t: +1-800-833-4882
t: +1-859-372-3244
Customer Service
t: +1-800-526-4960
t: +1-859-372-3214
e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road
Zhang Jiang Hi Tech Park
Shanghai 201203 PRC
Customer Service
t: +86 21 3861 9266
f: +86 21 3861 9599
e: info-engineeredmaterials-asia@celanese.com

Europe

Am Unisys-Park 1
65843 Sulzbach, Germany
Product Information Service
t: +49-800-86427-531
t: +49-(0)-69-45009-1011
e: info-engineeredmaterials-eu@celanese.com

Allgemeine Haftungsausschlußerklärung

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