

PC/ABS

D535

总览/Overview

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| 特点/Description | <ul style="list-style-type: none"> 综合性能好/Good comprehensive performance |
| 应用/Application | <ul style="list-style-type: none"> 电子电器/Electrical & electronic 办公用品/Office supplies |

通用 General	测试标准 Test Standard	测试条件 Test Condition	单位 Units	典型值 Typical Value
密度 Density	ASTM D792	23°C	g/cm ³	1.14
收缩率 Mold Shrinkage	INTERNAL	2mm	%	0.4-0.7
熔融指数 MFR	ASTM D1238	260°C,5kg	g/10min	20
阻燃性 Flammability	UL94	3.2mm	Class	/
机械特征 Mechanical	测试标准 Test Standard	测试条件 Test Condition	单位 Units	典型值 Typical Value
拉伸强度 Tensile Strength	ASTM D638	50mm/min	MPa	52
伸长率 Elongation at break	ASTM D638	50mm/min	%	50
弯曲强度 Flexural Strength	ASTM D790	2mm/min	MPa	75
弯曲模量 Flexural Modulus	ASTM D790	2mm/min	MPa	2000
悬臂梁缺口冲击强度 Impact Strength, IZOD notched	ASTM D256	3.2mm,23°C	KJ/m ²	55
耐热特征 Thermal	测试标准 Test Standard	测试条件 Test Condition	单位 Units	典型值 Typical Value
热变形温度 Heat Distortion	ASTM D648	1.8Mpa,3.2mm	°C	103

加工参数 Processing conditions	范围 Range
烘料条件 Pre-drying Condition	90°C-100°C, 3hr
注塑压力 Injection Pressure	60-100MPa
注塑速度 Injection Speed	50-80
模具温度 Mold Temperature	80°C
加工温度上限 Processing Temperature Max.	280°C
熔体温度 Melt Temperature	260°C
料筒温度-加料段 Cylinder Temperature-Feeding	230°C-250°C
料筒温度-中间段 Cylinder Temperature-Compressing	240°C-260°C
料筒温度-射嘴 Cylinder Temperature-Nozzle	250°C-270°C

a. 以上数据为本色料的数据，染色料的性能数据可能与以上数据不一样。The above data is for the original color material, and the properties of the dyeing material may differ from the above data.

b. 典型值是指实验室的平均数据，仅用于使用时参考，不作为产品标准。Typical values refer to the average data of the laboratory, which are only used as reference and are not used as product standards.

以上数值仅供参考使用，可根据制品大小、厚度以及产品要求做出调整 The above values are only for reference, and can be adjusted according to the size, thickness and requirements of the product.

Note:

1. 生产及操作时避免树脂接触到灰尘及杂物。 The resin should not contact with dust and sundries in processing.
2. 在射出周期中勿将热融胶长期停留在加热管中。 Do not Stay the resin in the heating tube for a long time during the injecting cycle.
3. 热浇道之系统温度不宜过高以免材料劣化。 The temperature of the hot runner should not be too high to avoid material degradation.
4. 加工的高温过程的水分控制是保证制品质量的关键之一。 The moisture control is one of the keys to ensure the quality of products in processing

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