

January 16, 2017 VIW

一般級 SAN, KIBISAN[®] PN-127加工建議條件

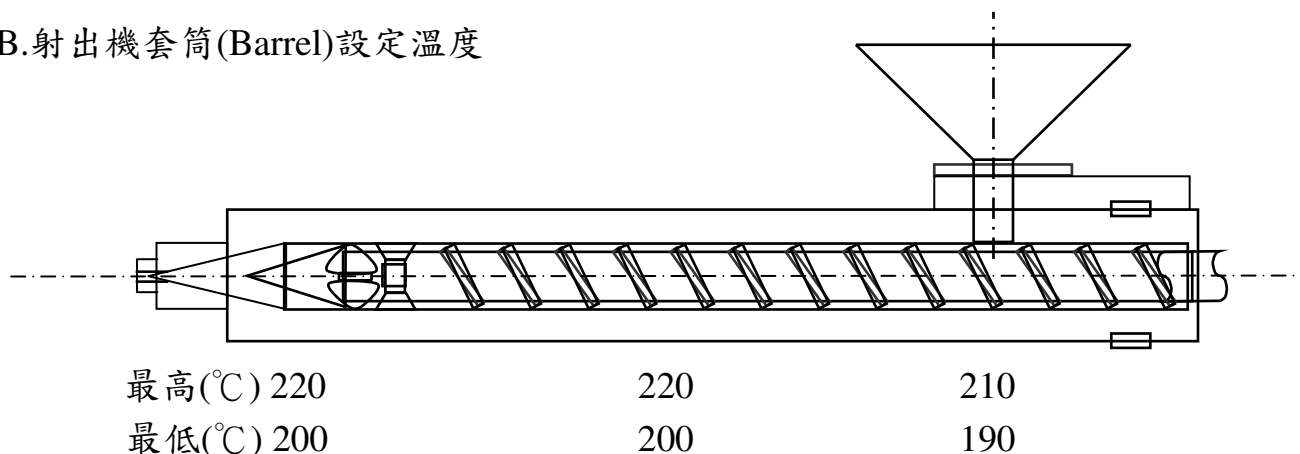
A 乾燥 : 75~80°C , 3~4 小時。

依以下變數而變 a)濕度

b)回收料比例

c)儲存條件

B.射出機套筒(Barrel)設定溫度



C. 模具溫度 40~60 °C。

依以下變數而變 a)製品厚度

b) 尺寸

c) 澆口(Gate)及流道(Runner)系統

D. 射壓 50~70 kg/cm²保壓 40~60 kg/cm²背壓 5~15 kg/cm²

備註：

1. 生產及操作時避免樹脂接觸到灰塵及雜物。
2. 在射出週期中勿將熱融膠(Hot Melt)長期停留在加熱管中。
3. 熱澆道之系統溫度不可超過240°C 以免材料劣化。

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奇美實業股份有限公司
CHI MEI CORPORATION

ORIGINAL

59-1, San Chia, Jen Te, Tainan City 71702, Taiwan

TEL : (06)2663000

FAX : (06)2665555-7

4. 若有任何疑問請洽06-2665000, 06-2663000

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