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防火級 ABS, POLYLAC® PA-765B

January 16, 2017 V1W

加工建議條件

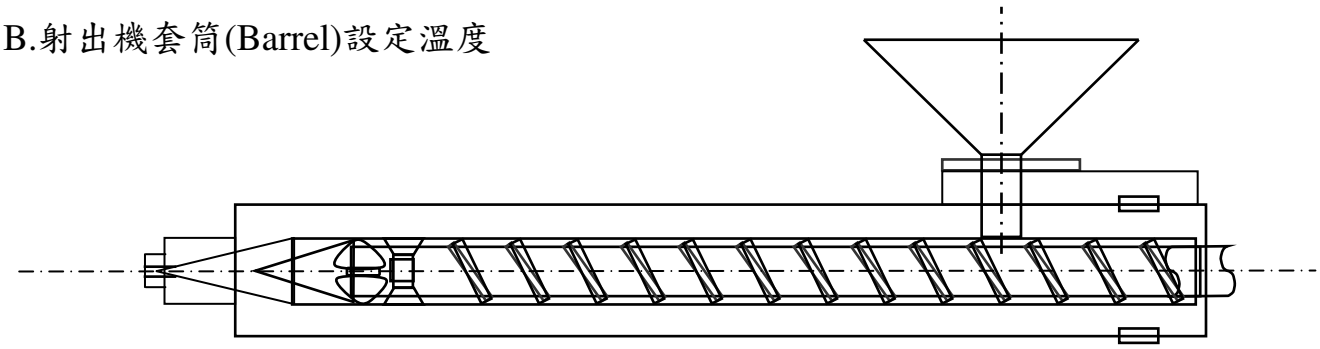
A 乾燥 ： 80 ~ 85 ℃，2 ~ 4 小時。

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



最高(℃)	220	220	210
最低(℃)	190	190	180

C. 模具溫度 40~70 ℃。

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 50~60 %

保壓 40~50 %

背壓 5~10 kg/cm^2

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. 滯留時間一般取決於料管大小、儲料量多寡及料管溫度而定。一般來說，料管溫度在220℃以下，滯留時間以不超過10分鐘為基準。
4. 若有任何疑問請洽 06-2665000, 06-2663000

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