

**阻燃級 WONDERLITE® PC-540**

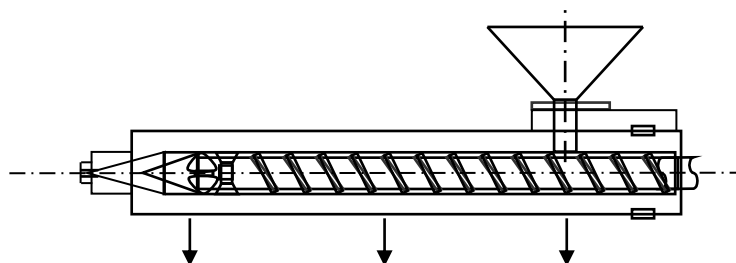
June 27, 2017 VIW

**加工建議條件：**

A 乾燥條件： 90°C x 4 hrs

- 與下列條件有關
- a) 環境濕度
  - b) 儲存條件
  - c) 乾燥機的乾燥狀況

B. 射出機溫度設定建議：



規格		噴嘴	壓縮段	進料段	模溫 *
PC-540	最高 (°C)	240	250	220	50 -100
	最低 (°C)	220	230	200	

- \* 隨下列條件而變動
- a) 成型品肉厚
  - b) 冷卻迴路設計
  - c) 澆口、澆道設計

**注意事項：**

1. 操作期間請避免原料受到任何污染。
2. 避免膠料在料管中高溫滯留過久。
3. 一般射出時，為避免膠料劣解，射出溫度請勿高於270°C。

**清料管建議 (Purging)：**

熱分解性的材料不可用於清除殘存餘射出機或押出機料管中的WONDERLITE®聚碳酸酯樹脂與WONDERLOY® PC/ABS樹脂。一般用於PC與PC/ABS的清管劑多為熱安定性較佳之樹脂，例如聚乙烯Polyethylene (PE)、聚丙烯Polypropylene (PP) ...等，即是廣為業者使用的清管材料。

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