

GB-1020

產品敘述: 1.0mm V0, PC/ABS+20%Mineral filled, contains 10% Post-Consumer Recycled (PCR) plastic

物性	ISO 測試方法	測試條件	單位	GB-1020
熔融指數	1133	260°C × 2.16KG	ml/10 min	48
比重	1183	23 °C	g/cm ³	1.32
拉伸強度	527	50 mm/min, yield	MPa	58
		50 mm/min, break	MPa	--
延伸率	527	50 mm/min	%	6.0
彎曲強度	178	2 mm/min	MPa	95
彎曲彈性模數		2 mm/min	GPa	4.1
IZOD 衝擊強度	180/4A	23 °C Notched	KJ/m ²	3.8
		-30 °C Notched	KJ/m ²	--
Charpy 衝擊強度	179	23 °C Notched	KJ/m ²	--
		-30 °C Notched	KJ/m ²	--
熱變形溫度	75/A	1.8 MPa Unannealed	°C	81
		1.8 MPa Annealed	°C	--
維氏軟化溫度	306	1 Kg, 50 °C/hr	°C	95
		5 Kg, 50 °C/hr	°C	--
表面電阻率	IEC 60093	--	Ohm	1E+16
線膨脹係數	11359	--	--	---
燃燒等級	--	UL-94	--	1.0mm V-0 2.0mm V-0 , 5VB 3.0mm V-0 , 5VB
成型收縮率	294-4	--	%	0.2~0.4
標記	1043	--	--	>PC+ABS-MD20 (REC10) FR(40)<

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Notes : These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests

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加工建議條件

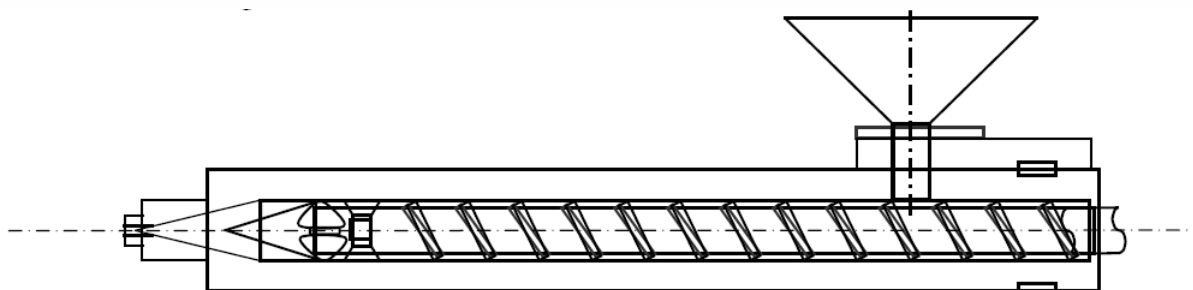
A. 乾燥條件 75~85 °C x 2~4 hrs

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. 射出機設定建議



機台	噴嘴	壓縮段	進料段	模溫
最高(°C)	250	260	230	60~80
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. 操作期間避免原料受到任何汙染.
2. 避免膠料在料管中高溫滯留過久.

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