

名称: PPGF40
 牌号: P107G



| 产品简介 Product Description | 主要应用 Applications |
|--|--|
| ·40%玻纤增强PP 40% glass fiber reinforced PP | ·注塑成型 Injection molding |
| ·优异的耐热老化性能 Excellent heat resistance performance | ·良好的机械性能, 尤其是刚韧平衡性 good mechanical properties, especially stiffness/toughness balance |

| 性能 Properties | 测试标准 Test Method | 测试条件 Test Condition | 单位 Unit | 典型值 Typical values |
|--|------------------|----------------------|-------------------|--------------------|
| 物理性能 Physical properties | | | | |
| 密度 Specific Gravity | ISO 1183 | 23°C | g/cm ³ | 1.225 |
| 灰份 Ash | ISO 3451 | 800°C,30min | % | 41 |
| 机械性能 Mechanical properties | | | | |
| 拉伸强度 Tensile Strength | ISO 527 | 5mm/min | MPa | 100 |
| 拉伸模量 Tensile Modulus | ISO 527 | 1mm/min | MPa | 9000 |
| 断裂伸长率 Elongation at break | ISO 527 | 5mm/min | % | 3 |
| 弯曲强度 Flexural Strength | ISO 178 | 2mm/min | MPa | 140 |
| 弯曲模量 Flexural Modulus | ISO 178 | 2mm/min | MPa | 8500 |
| 简支梁缺口冲击强度 Notched Charpy Impact Strength | ISO 179-1eA | 23°C | kJ/m ² | 13 |
| | | -30°C | kJ/m ² | 11 |
| 简支梁无缺口冲击强度 Unnotched Charpy Impact Strength | ISO 179-1/1fU | 23°C | kJ/m ² | 50 |
| | | -30°C | kJ/m ² | 48 |
| 热性能 Thermal properties | | | | |
| 热变形温度 Heat Deflection Temperature | ISO 75 | 1.80 MPa | °C | 150 |
| 熔点 Melting Point | ISO 11375 | DSC | °C | 163 |
| 其它性能 Other properties | | | | |
| 收缩率 shrinkage ⁽¹⁾ | internal method | flow direction | % | 0.10-0.30 |
| | | cross flow direction | % | 0.70-0.90 |

说明: 以上数据是典型值, 不是保证值。根据模具设计, 例如浇口类型, 浇口分布, 浇口数量的不同, 注塑工艺和制件厚度的不同, 测试结果会有波动。不同的颜色, 测试结果也会有波动。在使用材料之前, 请咨询旭光聚合物有限公司。

Note: The data above is typical value for reference, not guarantee value. The data will vary with tool design such as gate type, gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

| 典型加工条件 Processing Conditions ⁽²⁾ | | 参考范围 Range ⁽²⁾ |
|---|------------|---------------------------|
| 熔体温度 Melt Temperature | | 210-250°C |
| 料筒温度 Barrel Temperature | 后段, Rear | 220--235°C |
| | 中段, Center | 225--245°C |
| | 前段, Front | 240--260°C |
| 模具温度 Mold Temperature | | 50-80°C |
| 预干燥 Pre-Dry needed | | 90-110°C, 2-4h |

说明: (1) 收缩率板的尺寸为: 210*140*2.8mm。由于制件厚度, 浇口数量, 类型不同, 收缩率会有变化; 开模之前, 最好在类似的模具上试模;

(2) 以上数值仅供注塑机参考使用, 可根据不同机型、不同模具以及产品要求, 对上述工艺做适当调整。

Note: (1) The dimension of shrinkage plaque is 210*140*2.8mm. The part's shrinkage will have deviation due to part thickness, number of gate and type of gate; It is better to do mold trial on similar tool before cutting a new tool.

(2) The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

version 1: Jan. 2021