

ABS (CR-2031)

ABS Resin (CR-2031)

产品性能

Typical Properties

		测试标准	测试条件	典型值
		Test standard	Test Condition	Typical Value
物理性能 Physical	熔融指数 Melt Flow Index	ASTM D1238	220°C/10kg	20g/10min
	密度 Specific Gravity	ASTM D792	23°C	1.06g/cm ³
	成型收缩率 Mold Shrinkage	ASTM D955	23°C	0.3-0.6%
	洛氏硬度 Rockwell Hardness	ASTM D785	R	106
力学性能 Mechanical	拉伸强度 Tensile Strength	ASTM D638	50mm/min	45MPa
	断裂伸长率 Tensile Elongation	ASTM D638	50mm/min	12%
	弯曲强度 Flexural Strength	ASTM D790	1.3mm/min	65Mpa
	弯曲模量 Flexural Modulus	ASTM D790	1.3mm/min	2350Mpa
	悬臂梁缺口冲击强度 Izod Notched Impact Strength	ASTM D256	23°C	220J/m
热性能 Thermal	热变形温度(未退火) Heat Deflection Temperature (Unannealed)	ASTM D648	1.82MPa	81°C
燃烧 Firing	水平燃烧 Horizontal Burning	UL-94	3.0mm	HB

加工信息

Processing Guidelines

干燥条件 Drying	80-90°C, 2.0-4.0h
后段温度 Rear Temperature	190°C-210°C
中段温度 Middle Temperature	200°C-220°C
前段温度 Front Temperature	210°C-230°C
喷嘴温度 Nozzle Temperature	210°C-230°C
熔体温度 Melt Temperature	220°C-240°C

模温 Mold Temperature	80℃-90℃
注射压力 Injection Pressure	70-100MPa
背压 Back pressure	2-6MPa
螺杆转速 Screw Speed	40-60rpm

备注:

Note:

1. 所有数据为实验室典型值，仅供参考，不作为产品标准。
All data are typical values from laboratory. The data are used for reference only, not as production standard.
2. 生产时避免材料和其他材料、灰尘及杂物接触。
Avoid contact with other materials, dust and debris in the injection processing.
3. 注塑时避免材料长时间停留在螺杆中。
Avoid long time stay in the barrel in the injection processing.