增强 PC (HF-1031GF30)
Reinforced PC (HF-1031GF30)

一般信息 General Information				
	特征 Features	● 玻纤增强 ● 通用级 ● 高耐热 ● 高强度 ●尺寸稳定	Glass Fiber Reinforcement General Purpose High Heat Resistance High Rigidity Good Dimensional Stability	
	应用 Uses	● 电器产品 ● Electronics and Electrical Products		
	形态 Forms	● 粒子 ● Pellets		
	加工方法 Processing Method	● 注塑 ● Injection Molding		
产品性能 Typical Properties				
		测试标准 Test standard	测试条件 Test Condition	典型值 Typical Value
物理性能 Physical	熔融指数 Melt Flow Index	ASTM D1238	300℃/1.2kg	15g/10min
	密度 Specific Gravity	ASTM D792	23℃	1.43g/cm^3
	成型收缩率 Mold Shrinkage	ASTM D955	23℃	0.2-0.4%
力学性能 Mechanical	拉伸强度 Tensile Strength	ASTM D638	50mm/min	110MPa
	断裂伸长率 Tensile Elongation	ASTM D638	50mm/min	5%
	弯曲强度 Flexural Strength	ASTM D790	2.0mm/min	152MPa
	弯曲模量 Flexural Modulus	ASTM D790	2.0mm/min	6431MPa
	悬臂梁缺口冲击强度 Izod Notched Impact Strength	ASTM D256	23℃	170J/m
热性能 Thermal	热变形温度(未退火) Heat Deflection Temperature (Unannealed)	ASTM D648	1.82MPa	145℃
燃烧	阻燃性	UL-94	1.5mm	HB

Firing	Flammability	
加工信息 **Processing Guidelines**		
	干燥条件 Drying	90℃-110℃, 2.0-4.0h
	后段温度 Rear Temperature	220℃-250℃
	中段温度 Middle Temperature	230℃-290℃
	前段温度 Front Temperature	260℃-300℃
	喷嘴温度 Nozzle Temperature	270℃-300℃
	熔体温度 Melt Temperature	250℃-280℃
	模温 Mold Temperature	90℃-120℃
	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.