

名称: **PPGF20M10**

牌号: **P104MG**



产品简介 Product Description	主要应用 Applications
·20%玻纤增强聚丙烯,10%矿物填充 20% glass fiber reinforced PP and 10% mineral filled	·注塑成型 Injection molding
·优异的耐热老化性能 Excellent heat stability	·良好的机械性能 Good mechanical properties balance

性能 Properties	测试标准 Test Method	测试条件 Test Condition	单位 Unit	典型值 Typical Values
<b>物理性能 Physical properties</b>				
密度 Specific Gravity	ISO 1183	23°C	g/cm <sup>3</sup>	1.13
灰份 Ash	ISO 3451	650°C,30min	%	30
<b>机械性能 Mechanical properties</b>				
拉伸强度 Tensile Strength	ISO 527	5mm/min	MPa	60
弯曲模量 Flexural Modulus	ISO 178	2mm/min	MPa	4500
弯曲强度 Flexural Strength	ISO 178	2mm/min	MPa	90
简支梁缺口冲击强度 Charpy Notched Impact Strength	ISO 179-1eA	23°C	kJ/m <sup>2</sup>	8
简支梁无缺口冲击强度 Charpy Unnotched Impact Strength	ISO 179-1eU	23°C	kJ/m <sup>2</sup>	40
<b>热性能 Thermal properties</b>				
热变形温度 Heat Deflection Temp.	ISO 75	1.8 Mpa	°C	130
熔点 Melting Point	ISO 11375	DSC	°C	161
<b>其它性能 Other properties</b>				
收缩率 Mold Shrinkage <sup>(1)</sup>	internal test method	48 hours after tool	%	0.40-0.80
阻燃性 Flammability	ISO 3795	—	mm/min	29

**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 <sup>(2)</sup>		参考范围 Range <sup>(2)</sup>
熔体温度 Melt Temperature		210-250°C
料筒温度 Barrel Temperature	后段, Rear	210--220°C
	中段, Center	225--235°C
	前段, Front	240--250°C
模具温度 Mold Temperature		30-80°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.

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