物性表|Technical Data Sheet

广东顺德顺炎新材料股份有限公司
GUANGDONG SHUNDE SHUNYAN NEW MATERIAL CO.,LTD

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PA66HF230

描述 | Description

无卤玻纤增强阻燃 PA66，可镭雕

应用 | Applications

充电桩配件等等

性能项目 Performance Article	参考标准 Test method	测试条件 Test Condition	国际单位 S.I. Units	典型值 Typical Values
物理性能 Physical Properties				
玻纤含量 Glass Fiber Content	ISO 3451	--	%	25
收缩率 Mold Shrinkage	ISO 294	Flow direction,23℃ 流动方向	%	0.4
		Transverse direction,23℃ 垂直方向		0.6
吸水率 Water Absorption	ISO 62	23℃	%	1.5
比重 Density	ISO 1183	23℃	%	1.32
机械性能 Mechanical Properties				
拉伸强度 Tensile Strength	ISO 527	50 mm/min	MPa	120
断裂伸长率 Strain at break	ISO 527	50 mm/min	%	3.0
弯曲强度 Flexural Strength	ISO 178	2 mm/min	MPa	160
弯曲模量 Flexural Modulus	ISO 178	2 mm/min	MPa	6400
悬臂梁缺口冲击强度 Izod notched impact strength	ISO 180	4mm 23℃	kJ/m²	10
其他 Others				
阻燃性 Flammability	UL 94	1.6mm	Class	V0

1. 测试样条处理条件：制样后室温冷却 20 分钟。
   Allow the sample to cool at room temperature for 20 minutes after preparation.
2. 以上数据为该产品的代表性数据，仅用于使用时的参考，不作为该产品的标准及顺炎公司正式质保承诺。
   The above data represents typical values for this product, provided for reference during usage, and does not serve as the standard or official quality assurance commitment for Shunyan New Material.

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典型加工条件 Processing Conditions	典型值 Typical Values	范围 Range
熔体温度 Melt Temp.	275℃	270℃-280℃
料筒温度 Barrel Zone Temp.		
后段 Rear	265℃	260℃-270℃
中段 Center	270℃	265℃-275℃
前段 Front	275℃	270℃-280℃
模具温度 Mold Temp.	60℃	50℃-80℃
加工温度上限 Processing Temp. Limit		280℃
注塑速度 Injection Speed		中速到高速 Moderate to High
预干燥 Pre-Dry Requirements		120℃-130℃/4H

以上数值仅供参考使用，客户可根据不同注塑机型、不同模具以及产品具体要求，对上述工艺做适当调整。
The above values are for reference only. Customers may make appropriate adjustments to the mentioned process based on different injection molding machines, molds, and specific product requirements.

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