

耐熱級 ABS, POLYLAC[®] PA-777E

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加工建議條件

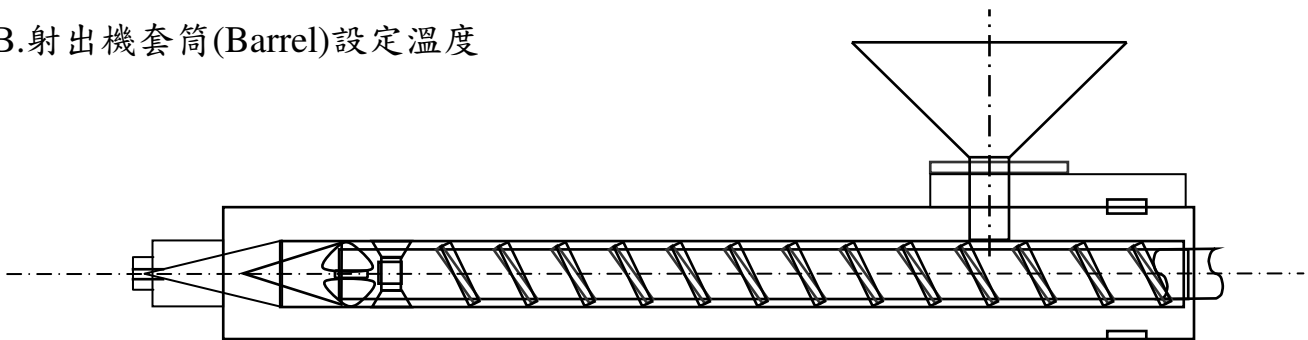
A 乾燥 : 100~110°C , 3 小時。

依以下變數而變 a)濕度

b)回收料比例

c)儲存條件

B.射出機套筒(Barrel)設定溫度



最高(°C) 270

270

250

最低(°C) 240

240

220

C. 模具溫度 40~80 °C。

依以下變數而變 a)製品厚度

b) 尺寸

c) 澆口(Gate)及流道(Runner)系統

D. 射壓 50~70 kg/cm²

保壓 40~60 kg/cm²

背壓 5~15 kg/cm²

備註：

1. 生產及操作時避免樹脂接觸到灰塵及雜物。
2. 在射出週期中勿將熱融膠(Hot Melt)長期停留在加熱管中。
3. 熱澆道之系統溫度不可超過280°C 以免材料劣化。
4. 若有任何疑問請洽 06-2665000, 06-2663000

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