苏州锦塑新材料有限公司

Suzhou Jinsu New Material Co.,Ltd

技术资料——PC/ABS SF65 HF

主要特征 CHARACTERISTICS	主要应用 APPLICATIONS
●可电镀 ●耐热 ●高冲击	● 内 饰产 品 ● 电 器部 品 ● 汽 车产 品

性能 Properties	测试方法 Test Method	测试条件 Test Condition	单位 Units	典型值 Typical Value
物理性能 Physical Performance				
比重 Density	ISO 1183	23℃	g/cm³	1.14
熔融指数 MI	ISO 1133	260℃,2.16kg	g/10min	7
收缩率 Shrinkage	ISO 2577	23℃	%	0.5~0.7
机械性能 Mechanical Performance				
拉伸强度 Tensile Strength	ISO 527	50mm/min	MPa	50
断裂伸长率 Elongation at Break	ISO 527	50mm/mi	%	≥50
弯曲强度 Flexural Strength	ISO 178	2mm/min	MPa	80
弯曲模量 Flexural Modulus	ISO 178	2mm/min	MPa	2200
简支梁缺口冲击强度 Charpy Notched impact Strength	ISO 179	23℃	kJ/m²	45
简支梁缺口冲击强度 Charpy Notched impact Strength	ISO 179	-30℃	kJ/m²	30
热性能 Thermal Performance				
热变形温度 Heat Deflection Temperature	ISO 75	0.45Mpa 未退火	℃	
	ISO 75	1.82MPa 未退火	℃	102
燃烧性能 Flammability				
UL-94 燃烧测试 UL-94 burning test	UL 94	1.6 mm	Class	HB
		2.0 mm	Class	HB
		3.2 mm	Class	HB
电气性能 Electrical Performance				
表面电阻 Surface Resistance	IEC 60093	1000V	Ω	1.00E+16
相对漏电起痕指数 CTI Comparative Tracking Index	IEC 60112	A 液	V	-
灼热丝 GWFI Glow-Wire Flammability Index	IEC 60695-2-12	1.5mm	℃	750

备注：

[1] 染色料的性能可能与以上数值存在差异。
The data sheet above may have differences when the material is colored.

[2] 典型值是指实验室平均数据，仅用于使用时的参考，不作为产品的标准。
The typical values which come from actually laboratory test results are shown for reference only.

建议加工条件 Suggested Processes Condition	范围 Range
干燥温度 Drying Temperature	90~100℃
干燥时间 Drying Time	3-4H
熔体温度 Melt Temperature	260℃-270℃
后段温度 Rear Temperature	230℃-255℃
中段温度 Middle Temperature	250℃-270℃
前段温度 Front Temperature	250℃-270℃
射嘴温度 Nozzle Temperature	250℃-270℃
模具温度 Mold Temperature	60℃-90℃
加工温度上限 Upper Limit ofProcessing Temperature	270℃
背压 Back Pressure	中 medium
注塑速度 Injection Speed	中速到高速 Moderate to fast

注：以上数值仅供参考使用，可根据不同机型，不同模具及产品要求，对上述工艺进行调整。

Tips: The data above is shown only for your reference, according to the specific processing machine , we should make some adjustment.

安全及处理注意事项 Safety & Handling Considerations

急救措施

若吸入熔融树脂逸出之气体，将患者移至通风处，立即送医。若接触到塑胶粒或塑胶粉末， 以清水冲洗。若接触到熔胶， 以大量（肥皂）水冲洗患部及衣物，立即送医。若接触到塑胶粒或塑胶粉末，以大量清水至少冲洗 15 分钟。若有不适，立即送医。若接触至高温熔融树脂逸出之气体，以大量清水至少冲洗 15 分钟。若有不适，立即送医。不慎吞食请催吐，以清水漱口，若有不适，立即送医。

FIRST AID MEASURES

Once inhaling ofevaporated gas when the resin is melted, move subject to open space and seek medical advice immediately. Once contact with pellets or powder, flush with clean water for 15min. Once contact with molten resin, flush with suds for 15min and seek medical advise immediately.Seek medical advise immediately ifany dis-comfortableness remains.Once swallowing accidentally, induce vomiting and rinse mouth with clean water. Seek medical advice ifnecessary.

安全处置与储存方法

处置操作处所须严禁烟火，做好整理整顿以避免粉尘累积。为防止尘爆， 空气输送管路，袋滤器及储槽须加装静电消除装置，并确实接地。袋滤器之滤材采导电性材质。储存存放于阴凉处所， 避免直射阳光，雨淋及急速之温差。储存处严禁烟火。

HANDLING AND STORAGE

Prohibit open fire and concentration ofdust or powder in processing site and warehouse. To avoid dust explosion resulting from the existence of powder, electrostatics eliminators and grounding should be equipped to air transferring pipes, bag filters and hoppers. Additionally, use electrically conductive filters for bag filters. Store the goods in a cool and dry place. Protect from direct sunlight, rain and violent temperature fluctuation. Fire is inhibited around storage area.

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