

EPONE Engineering Plastics

National innovation fund project enterprise

ISO9001:2008 certificated

ISO/TS16949 certificated

ZGDBGLD JQQG PA66T 进气歧管专用尼龙料

产品定义: PA66+PPA+GF

产品特点: 玻璃纤维增强, 注塑级, 突出的机械性能及热稳定性, 抗爆破能力强, 良好的流动性有助于成型, 表面光洁度优异。

产品应用: 汽车进气歧管等

ZGDBGLDJQQGPA66T is a glass fiber reinforced PA66/PPA for injection molding , it provides excellent mechanical properties and thermal-stability ,good performance at explosion resistance,easy processing due to its good flowability ,prominent surface finish.

Product applications: automotive intake manifold, etc

典型成型条件

typical molding process

干燥  
dry

鼓风烘箱(drum wind oven): 100-120°C, 4-6h ;  
热风循环(cycling warm air): 100-120°C, 4-6h ;  
真空烘箱(vacuum drying oven): 100-120°C, 3-4h

加工温度  
processing temperature

入料段(feed section): 265-275°C;  
熔融段(compressing section): 290-320°C;  
射嘴段(metering section): 290-310°C

背压  
back pressure

5-10Mpa

注射压力  
injection pressure

70-130Mpa

保压压力  
packing pressure

40-90Mpa

模具温度  
mold temperature

80-130°C

后处理  
post treatment

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其它  
others

本品流动性较好, 成型过程中可依情况适当降低注射压力及注塑温度  
Due to its good flowability , it is viable to reduce injection pressure & temperature properly.

以上数据仅供参考

All the information provided by EPONE only for reference

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For more information, please refer to <http://www.epone.com.cn>

产品性能参数

product performance parameters

性能 (properties)	测试标准 (test standard)	单位 (unit)	数据 (test result)
<b>物理性能 (physical properties)</b>			
密度 density	ISO 1183	g/cm <sup>3</sup>	1.41
熔点 melting temperature	ISO 11357	°C	270
<b>热变形温度 thermal deformation temperature</b>			
0.45MPa	ISO 75-2	°C	261
<b>成型收缩率 molding shrinkage</b>			
纵向 normal	ISO 25557/1	%	0.55
横向 parallel	ISO 25557/1	%	0.25
<b>机械性能 (mechanical properties)</b>			
<b>冲击 impact strength</b>			
无缺口冲击强度 non-notched	ISO 179	kJ/M <sup>2</sup>	70
缺口冲击强度 notched	ISO 179	kJ/M <sup>2</sup>	12
<b>拉伸 tensile</b>			
断裂强度 tensile strength	ISO 527-2	MPa	195
断裂伸长率 elongation at break	ISO 527-2	%	15
<b>弯曲 flexural</b>			
断裂强度 flexural strength	ISO 178	MPa	275
弯曲弹性模量 flexural modulus	ISO 178	MPa	11000
<b>硬度 hardness</b>			
洛氏硬度 rockwell hardness	ISO 2039-2	R	120
<b>电气性能 (electrical properties)</b>			
体积电阻率 volume resistivity	IEC 60093	Ω .cm	10 <sup>15</sup>
表面电阻率 surface resistivity	IEC 60093	Ω	10 <sup>14</sup>
介电强度 dielectric strength	IEC 60243	kV/mm	34
<b>燃烧性能 (flammability properties)</b>			
阻燃 flame retardant	UL 94	—	HB
氧指数 oxygen index	ISO4589	%	23

除特别说明外，以上数据均指在环境相对湿度 (RH) =0 及 23°C 条件下测得  
以上数据为典型值，仅供参考，不作质量保证之承诺。

All the data above was measured at 23°C and RH=0 unless otherwise stated, all is typical data, only for reference,  
not the permit of quality assurance.

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