

EPONE Engineering Plastics

National innovation fund project enterprise

ISO9001:2008 certificated

ISO/TS16949 certificated

ZGDBSLV PA6B33C

产品定义: PA6+ GF33%

产品特点: 33%玻璃纤维增强尼龙6, 表面光洁度优异

产品应用: 汽车风扇支架、电动工具外壳及配件等

ZGDBSLV PA6B33C is a 33% glass-fiber reinforced PA6 for injection molding, it provides prominent surface finish, in addition to providing good mechanical properties.

Product applications: vehicle fan stents, shell of electric tools and other accessory, etc

典型成型条件

typical molding process

干燥 dry	鼓风烘箱(drum wind oven): 100-120℃, 4-6h ; 热风循环(cycling warm air): 100-120℃, 4-6h ; 真空烘箱(vacuum drying oven): 100-120℃, 3-4h
加工温度 processing temperature	入料段(feed section): 215-225℃; 熔融段(compressing section): 250-280℃; 射嘴段(metering section): 250-280℃
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	70-100℃
后处理 post treatment	NA
其它 others	NA

以上数据仅供参考

All the information provided by EPONE only for reference

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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)
物理性能 (physical properties)			
密度 density	ISO 1183	g/cm ³	1.43
熔点 melting temperature	ISO 11357	°C	220
吸湿性 absorption of moisture			
23°C冷水中 24 小时 24 hours in 23°C water	ISO 62	%	---
成型收缩率 molding shrinkage			
纵向 normal	ISO 25557/1	%	0.85
横向 parallel	ISO 25557/1	%	0.45
机械性能 (mechanical properties)			
冲击 impact strength			
无缺口冲击强度 non-notched	ISO 179	kJ/M ²	65
缺口冲击强度 notched	ISO 180	kJ/M ²	12
拉伸 tensile			
断裂强度 tensile strength	ISO 527-2	MPa	170
断裂伸长率 elongation at break	ISO 527-2	%	12
弯曲 flexural			
断裂强度 flexural strength	ISO 178	MPa	245
弯曲弹性模量 flexural modulus	ISO 178	MPa	8800
硬度 hardness			
洛氏硬度 rockwell hardness	ISO 2039-2	R	120
电气性能 (electrical properties)			
体积电阻率 volume resistivity	IEC 60093	Ω .cm	10 ¹⁵
表面电阻率 surface resistivity	IEC 60093	Ω	10 ¹³
介电强度 dielectric strength	IEC 60243	kV/mm	22
燃烧性能 (flammability properties)			
阻燃 flame retardant	UL 94	—	HB

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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