

GCR-9110

產品敘述: 1.5mm V0, FR PC+10% glass fiber, contains 85% Post-Consumer Recycled (PCR) plastic

物性	ISO 測試方法	測試條件	單位	GCR-9110
熔融指數	1133	300°C × 1.2KG	ml/10 min	8.0
比重	1183	23 °C	g/cm ³	1.27
拉伸強度	527	50 mm/min, yield	MPa	60
		50 mm/min, break	MPa	---
延伸率	527	50 mm/min	%	8.0
彎曲強度	178	2 mm/min	MPa	100
彎曲彈性模數		2 mm/min	GPa	3.3
IZOD 衝擊強度	180/1A	23 °C Notched	KJ/m ²	10
		-30 °C Notched	KJ/m ²	--
Charpy 衝擊強度	179	23 °C Notched	KJ/m ²	--
		-30 °C Notched	KJ/m ²	--
熱變形溫度	75/A	1.8 MPa Unannealed	°C	140
		1.8 MPa Annealed	°C	--
維氏軟化溫度	306	1 Kg,50 °C/hr	°C	145
		5 Kg,50 °C/hr	°C	--
表面電阻率	IEC 60093	--	Ohm	1E+16
線膨脹係數	11359	--	--	5.00*10 ⁻⁵
燃燒等級	--	UL-94	--	0.5mm V-2
				1.5mm V-0
				3.0mm V-0
成型收縮率	294-4	--	%	0.3~0.5
標記	1043	--	--	>PC-GF10 (REC85) FR(65)<

January 1, 2021

Notes : These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests

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加工建議條件

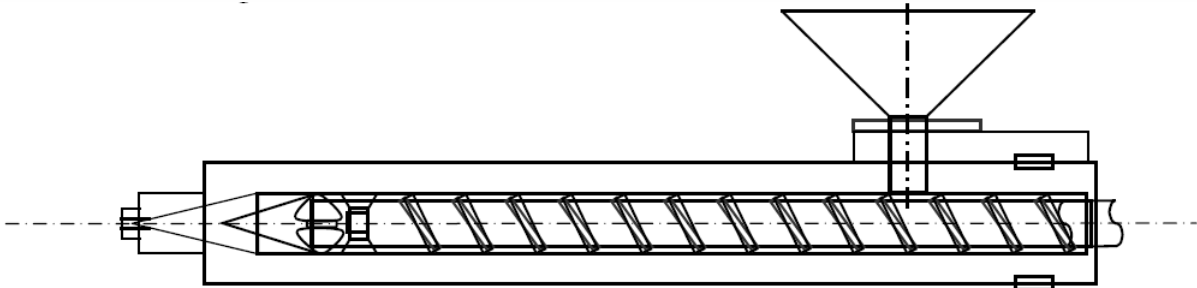
A. 乾燥條件 110~120 °C x 2~4 hrs

與下列條件有關 a) 環境濕度

b) 儲存條件

c) 乾燥機的乾燥狀況

B. 射出機設定建議



機台	噴嘴	壓縮段	進料段	模溫
最高(°C)	300	300	300	70~110
最低(°C)	260	260	250	

隨下列條件而變動 a) 成型品肉厚

b) 冷卻迴路設計

c) 澆口澆道設計

注意事項：

1. 操作期間避免原料受到任何汙染.
2. 避免膠料在料管中高溫滯留過久.

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