



Certificate Of Analysis

貨號Grade HR 550T

Date:

9-Dec-20

物性表 Properties

項目 Item	試驗法 Test Method	數據 Value	單位 Unit
硬度 Hardness	ASTM D2240	60	Shore A
比重 Specific Gravity	ASTM D792	0.92	g/cm ³
伸長率 Tensile Elongation	ASTM 412C	830	%
抗張強度 Tensile Strength	ASTM 412C	80	Kg/cm ²
撕裂強度 Tear Strength	ASTM 624C	49	Kg/cm
熔融指數 Melt Flow Index	ASTM D1238	4.7 E	g/10min
B: 125°C/2.16kg C:150°C/2.16kg			
E: 190°C/2.16kg G: 200°C/5kg			

建議成型條件 Processing Information

射出成型 Injection	Nominal Value	Unit
縮水率	0.8-1	%
烘料溫度 Drying Temperature	60	°C
烘料時間 Drying Time	1~2	hr
料管溫度(後段) Rear Temperature	160~175	°C
料管溫度(中段) Middle Temperature	165~180	°C
料管溫度(前段) Front Temperature	175~190	°C
加工熔體溫度 Processing (Melt) Temp	160~190	°C
模溫 Mold Temperature	16~66	°C
射出壓力 Injection Pressure	34~69	Mpa
背壓 Back Pressure	0.34~0.69	Mpa
螺桿轉速 Screw Speed	50~70	rpm
充填速度 Injection Speed	13~25	mm/sec

備註: Injection Notes

The values quoted here are typical of the grade,however,it is important to recognize that some variation around these values is to be expected as a result of uncertainties associated with measurement of the specific property and 以上所列之各項數據為實驗參考值，唯因使用時加工條件及環境之不同，而產生之差異非本公司所能保證與控制。

Moisture can degrade the material.Drying is suggested.This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 60°C

Ho Hsiang Ching Co.,LTD.

No.116-1, Qingguang Rd., Wuri Dist., Taichung City 414,Taiwan (R.O.C.)

TEL:+886-4-2335-8891 E-mail:hhc.tpe.sales@hhc-tpe.com

Website:www.hhc-tpe.com