



禾祥禎有限公司
Ho Hsiang Ching Co.,LTD.

貨號 Grade HR-400T

Date: 25-Jul-18

物性表 Properties			
項目 Item	試驗法 Test Method	數據 Value	單位 Unit
硬度 Hardness	ASTM D2240	40	Shore A
比重 Specific Gravity	ASTM D792	0.91	g3
伸長率 Tensile Elongation	ASTM 412C	878.6	%
抗張強度 Tensile Strength	ASTM 412C	34.7	Kg/cm ²
撕裂強度 Tear Strength	ASTM 624C	23.2	Kg/cm
融溶指數 Melt Flow Index	ASTM D1238	58.8 E	g/10min
流動指數 Flow Index :	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
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	160~177		°C
料管溫度(中段) Middle Temperature	166~182		°C
料管溫度(前段) Front Temperature	177~191		°C
熔化溫度 Nozzle Temperature	182~204		°C
加工熔體溫度 Processing (Melt) Temp	177~199		°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
緩衝 Cushion	3.81~25.4		mm

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 due to the normal variations encountered during the manufacturing process.

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 1 to 2 hours at 60°C

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