

## PA66 | KEPAMID 2320CF | 碳纤维增强牌号

- KEPAMID 2320CF是碳纤维20%增强的导电性PA66牌号
- 具有较好的机械性能、耐热性、耐磨损性和电气性能
- 适用于汽车、电子电气和工业中有耐热性、高刚性和导电需求的部件

| 物理性能                                                     | 测试标准       | 单位 | 数值   |
|----------------------------------------------------------|------------|----|------|
| 填充比例                                                     | ISO 1172   | %  | 20   |
| 比重                                                       | ISO 1183   | -  | 1.22 |
| 吸水率(23 °C, 50 % RH)                                      | ISO 62     | %  | -    |
| 收缩率(流动方向, $\Phi = 100 \text{ mm}$ , $t = 3 \text{ mm}$ ) | KEP Method | %  | -    |

| 机械性能          | 测试标准     | 单位                | 数值    |
|---------------|----------|-------------------|-------|
| 拉伸强度          | ISO 527  | MPa               | 245   |
| 断裂伸长率         | ISO 527  | %                 | 2.0   |
| 弯曲强度          | ISO 178  | MPa               | 340   |
| 弯曲模量          | ISO 178  | MPa               | 14300 |
| 简支梁缺口冲击强度     | ISO 179  | kJ/m <sup>2</sup> | 9.0   |
| 洛氏硬度(R-scale) | ISO 2039 | -                 | 120   |

| 热性能             | 测试标准      | 单位    | 数值  |
|-----------------|-----------|-------|-----|
| 熔点(10 °C/min)   | ISO 11357 | °C    | 260 |
| 热变形温度(0.45 MPa) | ISO 75    | °C    | 250 |
| 热变形温度(1.8 MPa)  | ISO 75    | °C    | -   |
| 燃烧性(t= 0.8 mm)  | UL 94     | Class | HB  |

| 电性能          | 测试标准      | 单位                       | 数值     |
|--------------|-----------|--------------------------|--------|
| 介电常数 (1 MHz) | IEC 60250 | -                        | 3.6    |
| 体积电阻率        | IEC 60093 | $\Omega \cdot \text{cm}$ | $10^3$ |

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## 注塑条件



### 预干燥 (建议最大吸水率为: 0.05 %)

推荐干燥条件: 80 °C, 4 ~ 6 h, 除湿干燥机

推荐干燥条件: 90 °C, 6 ~ 8 h, 热风干燥机

### 温度

模具温度: 70°C ~ 90 °C

料筒温度: 280°C ~ 290 °C

| 模具         | Bn (喷嘴) | B3 (计量) | B2 (压缩) | B1 (喂料) | 料斗         |
|------------|---------|---------|---------|---------|------------|
| 70 ~ 90 °C | 290 °C  | 285 °C  | 285 °C  | 280 °C  | 60 ~ 80 °C |

### 塑化

螺杆转速: 80 ~ 120 rpm

背压 : 5 ~ 10 kgf/cm<sup>2</sup>

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