

PA66 | KEPAMID 2333GF | 玻纤增强牌号

- KEPAMID 2333GF是玻纤33%增强PA66牌号。
- 具有高刚性和耐热性
- 适用于汽车、电子电气和工业中的部件

物理性能	测试标准	单位	数值
填充比例	ISO 1172	%	33
比重	ISO 1183	-	1.39
吸水率(23 °C, 50 % RH)	ISO 62	%	0.7
收缩率(流动方向, $\Phi = 100 \text{ mm}$, $t = 3 \text{ mm}$)	KEP Method	%	0.5 ~ 0.8

机械性能	测试标准	单位	数值
拉伸强度	ISO 527	MPa	195
断裂伸长率	ISO 527	%	3.0
弯曲强度	ISO 178	MPa	285
弯曲模量	ISO 178	MPa	9800
简支梁缺口冲击强度	ISO 179	kJ/m ²	11
洛氏硬度(R-scale)	ISO 2039	-	121

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	260
热变形温度(1.8 MPa)	ISO 75	°C	255
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	-	3.2
体积电阻率	IEC 60093	$\Omega \cdot \text{cm}$	10^{15}

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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/cm²

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