

PBT | KEPEX 3300M | 未填充牌号

- KEPEX 3300M 是非增强的易脱模的PBT牌号.
- 它拥有易脱模和优良的尺寸稳定性.
- 它适用于精密注塑件.

物理性能	测试标准	单位	数值
填充比例	ISO 1172	%	-
比重	ISO 1183	-	1.33
吸水率(23 °C , 50 % RH)	ISO 62	%	0.07
收缩率(流动方向, $\Phi = 100 \text{ mm}$, $t = 3 \text{ mm}$)	KEP Method	%	2.1

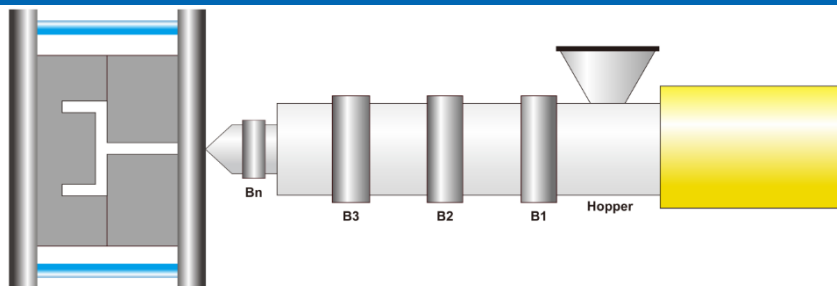
机械性能	测试标准	单位	数值
拉伸强度	ISO 527	MPa	63
断裂伸长率	ISO 527	%	15
弯曲强度	ISO 178	MPa	94
弯曲模量	ISO 178	MPa	2,800
简支梁缺口冲击强度	ISO 179	kJ/m ²	3.9
洛氏硬度(R-scale)	ISO 2039	-	118

热性能	测试标准	单位	数值
熔点(10 °C /min)	ISO 11357	°C	220
热变形温度(0.45 MPa)	ISO 75	°C	-
热变形温度(1.8 MPa)	ISO 75	°C	68
燃烧性(t= 0.8 mm)	UL 94	-	HB

电性能	测试标准	单位	数值
介电常数 (1 MHz)	IEC 60250	-	3.0
体积电阻率	IEC 60093	$\Omega \cdot \text{cm}$	10^{16}

Revision No. : 1 (2015-02-13)

注塑条件



预干燥 (建议最大吸水率为: 0.02 %)

推荐干燥条件 : 120 ~ 130 °C, 3 ~ 5 h, 热风干燥机

温度

模具温度 : 70 °C ~ 90 °C

料筒温度 : 230 °C ~ 250 °C

模具	Bn (喷嘴)	B3 (计量)	B2 (压缩)	B1 (喂料)	料斗
70~90 °C	250°C	240°C	240°C	230°C	60~80 °C

塑化

螺杆转速: 80 ~ 120 rpm

背压 : 5 ~ 10 kgf/cm²

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