

## PA.MXD6 | MAXIMID 7250GF | 玻纤增强牌号

- MAXIMID 7250GF 是50%玻纤增强的MXD6-PA/PA66牌号
- 它适用于汽车、电子电气和工业零部件

| 物理性能                                                     | 测试标准       | 单位 | 数值      |
|----------------------------------------------------------|------------|----|---------|
| 填充比例                                                     | ISO 1172   | %  | 50      |
| 比重                                                       | ISO 1183   | -  | 1.64    |
| 吸水率(23 °C , 50 % RH)                                     | ISO 62     | %  | 0.23    |
| 收缩率(流动方向, $\Phi = 100 \text{ mm}$ , $t = 3 \text{ mm}$ ) | KEP Method | %  | 0.4~0.5 |

| 机械性能          | 测试标准     | 单位                | 数值    |
|---------------|----------|-------------------|-------|
| 拉伸强度          | ISO 527  | MPa               | 280   |
| 断裂伸长率         | ISO 527  | %                 | 2     |
| 弯曲强度          | ISO 178  | MPa               | 390   |
| 弯曲模量          | ISO 178  | MPa               | 17000 |
| 简支梁缺口冲击强度     | ISO 179  | kJ/m <sup>2</sup> | 12.4  |
| 洛氏硬度(R-scale) | ISO 2039 | -                 | -     |

| 热性能                         | 测试标准      | 单位 | 数值  |
|-----------------------------|-----------|----|-----|
| 熔点(10 °C /min)              | ISO 11357 | °C | 238 |
| 热变形温度(0.45 MPa)             | ISO 75    | °C | -   |
| 热变形温度(1.8 MPa)              | ISO 75    | °C | 227 |
| 燃烧性( $t = 0.8 \text{ mm}$ ) | UL 94     | -  | HB  |

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

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## 注塑条件



### 预干燥 (建议最大吸水率为: 0.02 %)

推荐干燥条件 : 90 ~ 120 °C, 4 ~ 8 h, 除湿干燥机

### 温度

模具温度 : 120 °C ~ 140 °C

料筒温度 : 250 °C ~ 280 °C

| 模具         | Bn (喷嘴)    | B3 (计量)    | B2 (压缩)    | B1 (喂料)    | 料斗       |
|------------|------------|------------|------------|------------|----------|
| 120~140 °C | 270~280 °C | 265~275 °C | 260~270 °C | 250~260 °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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