

PA.MXD6 | MAXIMID 7550GF | 玻纤增强牌号

- MAXIMID 7550GF 是50%玻纤增强的MXD6-PA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	-	1.65
吸水率(23 °C , 50 % RH)	ISO 62	%	0.17
收缩率(流动方向, $\Phi = 100 \text{ mm}$, $t = 3 \text{ mm}$)	KEP Method	%	0.2~0.3

机械性能	测试标准	单位	数值
拉伸强度	ISO 527	MPa	295
断裂伸长率	ISO 527	%	2.0
弯曲强度	ISO 178	MPa	400
弯曲模量	ISO 178	MPa	18500
简支梁缺口冲击强度	ISO 179	kJ/m ²	11.5
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(1.8 MPa)	ISO 75	°C	232
线性膨胀系数	ISO 11359	X10 ⁻⁵ / °C	1.7
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 (100 Hz)	IEC 60250	-	4.5
介电常数 (1 MHz)	IEC 60250	-	4.7
耗散因数 (100 Hz)	IEC 60250		0.098
耗散因数 (1 MHz)	IEC 60250		0.024
表面电阻率	IEC 60093	Ω	3x10 ¹⁶
体积电阻率	IEC 60093	$\Omega \cdot \text{cm}$	1x10 ¹⁶
介电强度	IEC 60243	KV/mm	18

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 : 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/cm²

联系方式

总部

Mapo-daero 119 (Gongdeok-dong),
Mapo-gu, Seoul, Korea
Tel 82-2-707-6840 ~ 8, Telefax 82-2-714-9235

KEP Europe GmbH

Rheingaustrasse 190-196 D-65203 Wiesbaden
Germany
Tel +49 (0) 611 962-7381, Telefax +49 (0) 611 962-9132

KEP 美国

106 North Denton Tap Road Suite 210-202 Coppell,
TX 75019, USA
Tel +1 888 KEPITAL, Telefax +1 888 537-3291

KEP 中国

上海市长宁区遵义路 100 号虹桥南丰城 A1905

Tel +86 21 6237-1972, Telefax +86 21 6237-1803

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