

Chemlon® AF417

Teknor Apex 公司 - 聚酰胺 66

加工信息

注射	干燥 单位制
干燥温度	176 到 212 °F
干燥时间	2.0 hr
料筒后部温度	518 到 554 °F
料筒中部温度	518 到 554 °F
料筒前部温度	518 到 554 °F
加工 (熔体) 温度	< 572 °F
模具温度	140 到 176 °F
注射速度	快速
螺杆转速	50 到 200 rpm

注射说明

Back Pressure: Low

Injection Pressure: High

The material is supplied dry and ready to mould in sealed, moisture proof sacks. No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present. Should drying become necessary two hours at 80 - 100°C in a vacuum oven is recommended. Alternatively material maybe dried for up to six hours in a hopper drier or an air-circulating oven at a temperature not exceeding 80°C.

备注

¹ 一般属性：这些不能被视为规格。

² Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

³ Break

⁴ Yield