



Eastech
亿科化学



聚合睿见 塑造无限

临时技术规格书

Provisional Technical Data Sheet

全球领先高性能聚合物材料制造商 & 客户一体化解决方案提供者

亿科化学有限责任公司
www.eastechchemical.com

ABS 产品资料 Product Information

产品牌号: F332

产品特性 Product features

Excellent glossiness	✦ 极佳的光泽度
Medium heat resistance	✦ 中等耐热
Medium impact	✦ 中等冲击

产品应用 Applications

Auto applications	✦ 汽车
Home appliances	✦ 家电
Household items & Modification	✦ 家居用品及改性

信息参数 Information parameters

性能 Properties	测试方法 Test Standard	测试条件 Test Condition	单位 Unit	典型值 Typical value ^[1,2]
物理性能 Physical properties				
密度 Density	ISO 1183	23°C	g/cm ³	1.04
熔体质量流动速率 Melt mass-flow rate(MFR)	ISO 1133	220°C/10kg	g/10min	15
机械性能 Mechanical properties(23°C/50% r. h.)				
拉伸屈服强度 Tensile strength at yield	ISO 527	50mm/min	MPa	48
屈服应变 Strain at yield	ISO 527	50mm/min	%	3.0
拉伸模量 Tensile modulus	ISO 527	1mm/min	MPa	2400
洛氏硬度 Rockwell hardness	ISO 2039/2	R Scale	/	110
弯曲强度 Flexural strength	ISO 178	2mm/min	MPa	68
弯曲模量 Flexural modulus	ISO 178	2mm/min	MPa	2200
悬臂梁缺口冲击强度 Izod notched impact strength	ISO 180/1A	23°C, 5.5J	kJ/m ²	17
热性能 Thermal properties				
维卡软化温度 Vicat Softening temperature	ISO 306	50N, 50°C/h	°C	103
模塑收缩率 Molding shrinkage	ISO 294/4	23°C	%	0.4~0.7

[1]数据为典型值，仅供参考，不作为品质指标及其他用途的保证；The data are typical values for reference only and are not used as quality indicators or other purposes;

[2]不同颜色的产品其性能可能会不同。Different colors of products may have different properties.

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建议加工及干燥条件 Recommended processing & Drying conditions

- * 干燥时间 Drying time 2~4h
- * 干燥温度 Drying temperature 80~90°C
- * 干燥设备 Drying equipment 热风式干燥机 Hot air dryer

注塑成型工艺 Injection molding process

相关条件 Related conditions

		典型值 Optimum	范围 Range
熔体温度	Melt Temp.	220°C	210~230°C
料筒温度	Barrel Temp.	后段, Rear	210°C
		中段, Middle	215°C
		前段, Front	220°C
		喷嘴, Nozzle	220°C
加工上限温度	Processing Temp. Upper Limit	260°C	
注射压力	Injection Pressure	40~100MPa	
注射速度	Injection Speed	40~80mm/s	
塑化背压	Plasticization Back Pressure	5~20MPa	
建议模具温度	Recommended Mold Temp.	40~80°C	

以上加工参数仅供参考, 实际工艺参数应根据不同机型、不同模具以及不同产品等进行适当调整。

The above processing parameters are for reference only. Actual process parameters should be adjusted appropriately according to different models, different molds and different products.

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