

UNIKING® PC 4601

特征 Features

光扩散PC, 柔光效果, 高流动, 易成型
Light diffusion PC resin, soft light effect, high flow, easy mold

应用 application

LED灯罩
LED lampshade

项目 Items	测试方法 Standard	测试条件 Condition	单位 Unit	典型值 Typical Value
物理性能 Physical properties				
比重 Specific Gravity	ISO 1183	---	g/cm ³	1.20
熔融指数 Mass Melt Flow Rate	ISO 1133	300°C/1.2Kg	g/10min	25
成型收缩率 Molding Shrinkage	ISO 294	Flow, 3.2mm	%	0.55-0.75
		X-flow, 3.2mm	%	0.55-0.75
光泽度 Surface gloss	ISO 2813	60°	Gu	---
吸水率 Moisture Absorption	ISO 62	24h, 平衡	%	0.2
力学性能 Mechanical properties				
拉伸强度, 屈服 Tensile Strength, Yield	ISO 527	20mm/min	Mpa	62
断裂伸长率, 断裂 Elongation at Break	ISO 527	20mm/min	%	>40
弯曲强度 Flexural Strength	ISO 178	2mm/min	Mpa	90
弯曲模量 Flexural Modulus	ISO 178	2mm/min	Mpa	2200
悬臂梁缺口冲击强度 Izod Impact, Notched	ISO 180	5.5J, 23°C	KJ/m ²	52
		5.5J, -30°C	KJ/m ²	12
热性能 Thermal properties				
热变形温度 HDT, un annealed	ISO 75	1.8Mpa	°C	127
维卡软化温度 Vicat Softening Temperature	ISO 306	50A	°C	141
线性膨胀系数 CLTE	ISO 11359	-40~40°C	Cm/°C/°C	90*10 ⁻⁶
阻燃性能 Flammability	UL94	1.6mm	Grade	HB
		3.2mm	Grade	V2
电气性能 Electrical properties				
相对介电常数 Relative Permittivity	IEC 60250	1MHz	---	3.2
介电强度 Dielectric Strength	IEC 60243	S/T, in oil	KV/mm	22
功耗因数 Dissipation Factor	IEC 60250	1MHz	---	0.033
体积电阻率 Volume Resistivity	IEC 60112	23°C	ohm•cm	1.0E+16

1) 染色料的性能可能与以上数值有不同。所有数据是在 23°C、50% 相对湿度的环境中存放 48 小时后测试所得。除流动指数外的其它性能均使用注塑样条进行测试的。

Variations within normal tolerances are possible for various colors. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt flow rates, are measured on injection molded samples.

2) 典型值是指实验平均数据, 仅用于使用时的参考, 不作为产品的标准。

Only typical data for selection purposes. Property values is the average experimental data, when used only for reference, not as a product standards.

加工信息
Processing information

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建议加工条件 Suggested Processes Condition		
干燥温度 Drying Temperature	°C	80~120
干燥时间 Drying Time	H	2~4
建议最大湿含量 Suggested Max Moisture	%	<0.015
后段温度 Rear Temperature	°C	240~280
中段温度 Middle Temperature	°C	250~290
前段温度 Front Temperature	°C	250~300
射嘴温度 Nozzle Temperature	°C	250~300
成型(熔体)温度 Processing(Melt) Temperature	°C	250~290
模具温度 Mold Temperature	°C	50~80
注塑压力 Injection Pressure	Mpa	70~140
注塑速度 Injection Rate		中等速度
背压 Back Pressure	Mpa	0.1~0.3
螺杆转速 Screw Speed	rpm	30~70

以上数值为实验室测得，实际可能会有所不同，可根据不同机型、不同模具以及产品要求，做适当调整。
Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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Flammability

Flammability results are based on small-scale laboratory tests for purposes of relative comparison and are not intended to reflect the hazards presented by this or any other material under actual fire conditions.

安全防护

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