

UNIKING® PP 6115

特征 Features

15%玻璃纤维增强, 标准型
15%glass fiber reinforced, standard

应用 application

汽车部件、电动工具、机械部件
Automotive parts、power tools、machine parts

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	1.01
熔融指数 Mass Melt Flow Rate	ISO 1133	230℃/2.16Kg	g/10min	—
成型收缩率 Molding Shrinkage	ISO 294	Flow, 3.2mm	%	0.9
		X-flow, 3.2mm	%	1.1
燃烧残余 Ash Content	ISO 3451	750℃, 30min	%	15
吸水率 Moisture Absorption	ISO 62	24h, 平衡	%	0.2
力学性能 Mechanical properties				
拉伸强度 Tensile Strength	ISO 527	50mm/min	MPa	60
断裂伸长率 Elongation at Break	ISO 527	50mm/min	%	3
弯曲强度 Flexural Strength	ISO 178	2mm/min	MPa	90
弯曲模量 Flexural Modulus	ISO 178	2mm/min	MPa	3000
悬臂梁缺口冲击强度 Izod Impact, Notched	ISO 180	5.5J, 23℃	KJ/m ²	8
		5.5J, -30℃	KJ/m ²	—
热性能 Thermal properties				
热变形温度 HDT, un annealed	ISO 75	1.8Mpa	℃	120
维卡软化温度 Vicat Softening Temperature	ISO 306	A50	℃	—
线性膨胀系数 CLTE	ISO 11359	-40~40℃	Cm/℃/℃	—
氙灯加速老化 Xenon lamp accelerated aging	SAE J2527	2500KJ/m ²	—	—
阻燃性能 Flammability	UL94	3.2mm	Grade	HB
电气性能 Electrical properties				
相对介电常数 Relative Permittivity	IEC 60250	1MHz	—	—
介电强度 Dielectric Strength	IEC 60243	S/T, in oil	KV/mm	—
功耗因数 Dissipation Factor	IEC 60250	1MHz	—	—
体积电阻率 Volume Resistivity	IEC 60112	23℃	ohm•cm	—

1)染色料的性能可能与以上数值有不同。所有数据是在 23℃、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℃/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.

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建议加工条件 Suggested Processes Condition		
干燥温度 Drying Temperature	°C	90~100
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	190~210
中段温度 Middle Temperature	°C	200~230
前段温度 Front Temperature	°C	200~230
射嘴温度 Nozzle Temperature	°C	200~230
成型(熔体)温度 Processing(Melt) Temperature	°C	200~230
模具温度 Mold Temperature	°C	80~100
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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燃烧性能的结果仅为小规模实验室检测所得,不能反映灾害或任何其他材料在实际火灾中的燃烧情况。

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.

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