POM | KEPITAL FG2015 | 增强填充牌号

- 普通注塑成型的玻纤增强牌号
- 应用于高强度、高刚性、高热变形温度和高耐蠕变性需求的部件

物理性能	测试标准	单位	数值
密度	ISO 1183	g/cm^3	1.50
熔融指数	ISO 1133	g/10min	11.5
吸水率(23 ºC / 50 % RH)	ISO 62	%	0.2

热性能	测试标准	单位	数值
热变形温度(1.8 MPa)	ISO 75	ºC	161
燃烧性	UL 94	-	HB
熔点(10 ºC/min)	ISO 11357	ºC	165
线膨胀系数	ISO 11359	X 10^{-5}/ ºC	5

机械性能	测试标准	单位	数值
拉伸强度	ISO 527	MPa	120
屈服伸长率	ISO 527	%	-
断裂伸长率	ISO 527	%	3.6
弯曲强度	ISO 178	MPa	175
弯曲模量	ISO 178	MPa	5 ,200
简支梁缺口冲击强度	ISO 179	kJ/㎡	7.0

电性能	测试标准	单位	数值
表面电阻率	IEC 60093	Ω	1x10^{16}
体积电阻率	IEC 60093	Ω · cm	1x10^{14}
介电强度	IEC 60243-1	kV/mm	-

其他	测试标准	单位	数值
收缩率(流动方向, Φ = 100 mm, t = 3 mm)	KEP 方法	%	0.8

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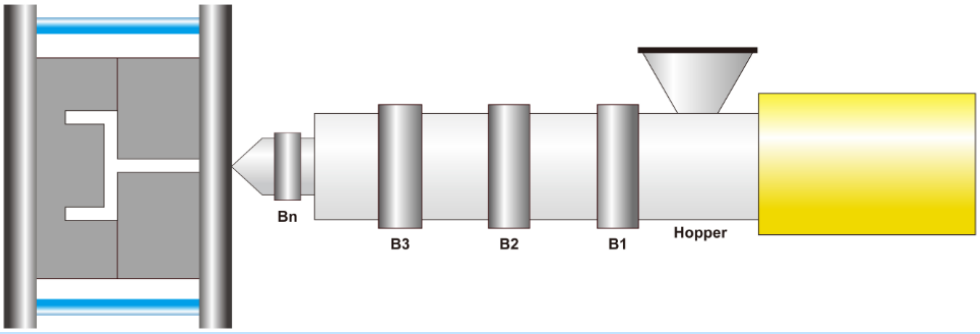
注塑条件



预干燥(建议最大吸水率为：0.1 %)

推荐干燥条件 80 ºC ~ 100 ºC, 3 h ~ 4 h

温度

模具温度: 60 ºC ~ 80 ºC
料筒温度: 180 ºC ~ 210 ºC

模具	Bn (喷嘴)	B3 (计量)	B2 (压缩)	B1 (喂料)	料斗
60 ~ 80 ºC	180 ~ 210 ºC	190 ~ 200 ºC	180 ~ 190 ºC	170 ~ 180 ºC	60 ~ 80 ºC

塑化

螺杆转速: 150 mm/s ~ 200 mm/s
背压: 最大 20 bar

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