

PBT日本宝理低密度 填充级流动性高

产品名称	PBT日本宝理低密度 填充级流动性高
公司名称	京冀（广州）新材料有限公司
价格	18.00/件
规格参数	颗粒:耐水解 注塑级:耐化学性 日本宝理:润滑PBT原料
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产品详情

聚对苯二甲酸丁二醇酯，英文名polybutylene

terephthalate（简称PBT），属于聚酯系列，是由1,4-丁二醇(1,4-Butylene glycol)与对苯二甲酸(PTA)或者对苯二甲酸酯(DMT)聚缩合而成，并经由混炼程序制成的乳白色半透明到不透明、结晶型热塑性聚酯树脂。

与PET一起统称为热塑性聚酯，或饱和聚酯。日本宝理PBT-工艺特点：PBT注塑之前一定要在110~120

的温度下干燥3小时左右，成型加工温度为250~270，模温控制在50~75为宜。因该料从熔融状态一经冷却，则会立即凝固结晶，故其冷却时间较短；若喷嘴温度控制不当（偏低），流道（水口）易冷却固化，会出现堵嘴现象。若料筒温度超过275或熔料在料筒中停留时间超过30分钟，易引起材料分解

变脆。PBT注塑时需用较大水口进胶，不宜使用热流道系统，模具排气要良好，宜用“高速、中压、中温”的条件成型加工，防火料或加玻纤的PBT水口料不宜再回收利用，停机时需用PE或PP料及时清洗料管，以免碳化。PBT 209aw-process characteristics PBT must be dried at 110-120 ° C for about 3 hours before injection molding, molding temperature is 250-270 ° C, mold temperature is 50-75 ° C. If the temperature of the nozzle is improperly controlled (on the low side), the flow channel (nozzle) is easy to be cooled and solidified, and the nozzle will be blocked. If the barrel temperature exceeds 275 ° C or the molten material stays in the barrel for more than 30 minutes, it is easy to cause the material to decompose and become brittle. PBT injection needs larger inlet glue, not hot runner system, mold exhaust should be good, suitable for “ High speed, medium pressure, medium temperature ” molding conditions, fireproof material or PBT nozzle material with glass fiber should not be recycled. PE or PP material should be cleaned in time to avoid carbonization.

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PBT 日本宝理--工艺条件：干燥处理：这种材料在高温下很容易水解，因此加工前的干燥处理是很重要的。建议在空气中的干燥条件为120，6~8小时，或者150，2~4小时。湿度必须小于0.03%。如果用吸湿干燥器干燥，建议条件为150，2.5小时。熔化温度：225~275，建议温度：250。模具温度：对于未增强型的材料为40~60。要很好地设计模具的冷却腔道以减小塑件的弯曲。热量的散失一定要快而均匀。建议模具冷却腔道的直径为12mm。注射压力：中等（*大到1500bar）。注射速度：应使用尽可能快的注射速度（因为PBT的凝固很快）。流道和浇口:建议使用圆形流道以增加压力的传递（经验公式：流道直径=塑件厚度+1.5mm）。可以使用各种型式的浇口。也可以使用热流道，但要注意防止材料的渗漏和降解。浇口直径应该在0.8~1.0*t之间，这里

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easily hydrolyzed at high temperatures, so pre-processing drying is important. It is suggested that the air should be dried at 120 ° C for 6 ~ 8 hours, or at 150 ° C for 2 ~ 4 hours. Humidity must be less than 0.03% . If drying with a hygroscopic dryer, the recommended condition is 150 ° C, 2.5 hours. Melting Temperature: 225 ~ 275 ° C, recommended temperature: 250 ° C. Die Temperature: 40 ~ 60 ° C for unreinforced material. The cooling channel of the mold should be well designed to reduce the bending of the plastic parts. Heat must be lost quickly and evenly. It is suggested that the diameter of cooling cavity is 12mm. Injection Pressure: medium (up to 1500 bar) . Injection Speed: use the injection speed as fast as possible (because PBT solidifies quickly) . Runner and gate: Circular Runner is recommended to increase pressure transfer (empirical formula: runner diameter = plastic thickness + 1.5 mm) . Various types of gates can be used. Hot Runner may also be used, but care must be taken to prevent material leakage and degradation. The gate diameter should be between 0.8 and 1.0 * t, where T is the plastic thickness. For submerged gates, a minimum diameter of 0.75 mm is recommended.

PBT日本宝理--性能及应用：PBT又可称为热塑性聚酯塑料，为适用于不同加工业者使用，一般多少会加入添加剂，或与其它塑料掺混，随着添加物比例不同，可制造不同规格的产品。由于PBT具有耐热性、耐候性、耐药品性、电气特性佳、吸水性小、光泽良好，广泛应用于电子电器、汽车零件、机械、家用品等，而PBT产品又与PPE、PC、POM、PA等共称为五大泛用工程塑料。

PBT can also be called thermoplastic polyester plastic, for the use of different processing industry, generally more or less will add additives, or mixed with other plastics, with different proportions of additives, can be made of different specifications of products. Because PBT has heat resistance, weather resistance, drug resistance, good electrical properties, water absorption is small, good luster, widely used in electronic appliances, automotive parts, machinery, household goods, etc. , and PBT products and PPE, PC, Pom, PA and so on are called five general engineering plastics.