

PBT耐高温BK注塑级阻燃

产品名称	PBT耐高温BK注塑级阻燃
公司名称	京冀（广州）新材料有限公司
价格	18.00/件
规格参数	PBT:BK注塑级 组立加工容易:耐热性（耐热裂化）佳 耐磨耗:电气性质佳
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产品详情

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PE或PP料及时清洗料管，以免碳化。

Process features: 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.

特性良好 粘结性 冲击性能 额定值 单位制 测试方法 简支梁缺口冲击强度 (23 ° C) 7.0 kJ/m ISO 179/1eA 可燃性 额定值 单位制 测试方法 UL 阻燃等级 HB UL 94 热性能 额定值 单位制 测试方法 热变形温度 (1.8 MPa, 未退火) 206 ISO 75-2/A 线形热膨胀系数 横向: 23 到 55 ° C 1.0E-4 cm/cm/ ° C 内部方法 流动: 23 到 55 ° C 4.0E-5 cm/cm/ ° C 内部方法 电气性能 额定值 单位制 测试方法 体积电阻率 6.0E15 ohms · cm IEC 60093 介电强度 (3.00 mm) 19 kV/mm IEC 60243-1

加工条件 干燥温度 () 110~120 干燥时间约 (hr) 2~3 模具温度 () 50~75 残料量 (mm) 2~6 熔胶温度 () 250~270 背压 (MPa) 5~10 注射压力 (MPa) 100~140 锁模力约 (ton/in²) 3~4 注塑速度 高速 回料转速 (rpm) 70~90 螺杆类别 标准螺杆 (直通式喷嘴) 停机处理 关料闸啤清即可

碎料翻用 (%) 15 ~ 25备注：防火PBT需要用PE料过炮，水口料不宜回收利用。

Standard test method for notched impact strength of simply supported beams (23 ° C)7.0 kJ/M² ISO 179/1EA
flammability, rating, unit, test methods-UL flame retardant grade Hul 94-thermal performance, rating, system of units,
test method thermal deformation temperature (1.8 MPA, non-annealed)206 ° C ISO 75-2 a linear Coefficient of
thermal expansion transversal: 23 to 55 ° C 1.0 E-4 cm/cm ° C internal method flow: 23 to 55 ° C 4.0 E-5
CMCMCM ° C internal method electrical performance, rating, system of units, test Method Volume Resistivity
6.0E15 ohms · cm IEC 60093 dielectric strength (3.00 mm)19 kv/mm IEC 60243-1 processing conditions drying
temperature (° C)110-120 drying time approximately (hr)2-3 mold temperature (° C)50-75 residue amount
(mm)2-6 melt glue temperature (° C)250-270 back pressure (MPa)5-10 injection pressure (MPa)100-140 clamping
force approximately (ton/IN²)3-4 injection speed high speed turn-back rate (rpm)70-90 screw type standard screw
(through nozzle) shut down to clean the closing gate, scrap reuse (%)15-25 remarks: Fire PBT needs to use PE
material over the gun, nozzle material is not suitable for recycling.