

阻燃PBT D202G30

产品名称	阻燃PBT D202G30
公司名称	东莞市晶宏塑胶原料有限公司
价格	.00/个
规格参数	品牌:台湾新光 型号:D202G30 特性:阻燃
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产品详情

阻燃PBT D202G30--Shinite PBT d202g30 is a polybutylene terephthalate (PBT) material with a 30% glass fiber reinforced filler. The product is available in North America,.

Shinite PBT d202g30 features:

Flame retardant / rated flame

Flame Retardant

The PBT process requires that PBT must be dried at 110-120 for about 3 hours before injection molding. The molding temperature is 250-270 , and the mold temperature is 50-75 . Once the material is cooled from the melting state, it will solidify and crystallize immediately, so its cooling time is short; if the nozzle temperature is not properly controlled (on the low side), the flow channel (nozzle) is easy to cool and solidify, and the phenomenon of nozzle plugging will occur. If the barrel temperature exceeds 275 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. During PBT injection molding, a large water inlet is required, and hot runner system is not suitable. The mold exhaust shall be good. It is suitable to use the conditions of "high speed, medium pressure and medium temperature" for molding and processing. The fire-proof material or glass fiber PBT water inlet material shall not be recycled. When the machine is stopped, PE or PP material shall be used to clean the material pipe in time to avoid carbonization.

Drying temperature () 110-120 drying time (HR) 2-3

Mold temperature () 50-75, scrap quantity (mm) 2-6

Glue temperature () 250-270 back pressure (MPA) 5-10

Injection pressure (MPa) 100-140 mold locking force (ton / in²) 3-4

Injection speed: high speed; return speed (RPM): 70-90

Screw category standard screw (through nozzle)

Shut down the machine for treatment, turn off the material gate for clearing, then turn over the crushed material (%).
15-25

Remark: PE material should be used in the fire PBT, and the nozzle material should not be recycled.