

# PBT 733LD

产品名称	PBT 733LD
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:日本宝理 型号:733LD 特性:低翘曲性
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## 产品详情

PBT 733LD--When using the oven dryer, the resin should be spread on the tray with a thickness of about 1 inch. For large particle recycled materials, the retention time should be increased to 4-6 hours. In order to avoid excessive heat accumulation, it is suggested that the drying time of materials should not exceed 48 hours. When using the automatic system, always use hot air to transfer the pre dried materials to the hopper, so as to minimize water absorption. It is recommended that the amount of material in the hopper should not exceed that used for half an hour production. Hopper cover shall be kept closed to avoid moisture absorption of resin. Melt temperature: in order to obtain the appropriate melt temperature, the barrel temperature distribution should be set, and the temperature from hopper to machine nozzle should gradually increase. It is recommended that the melt temperature range of enduran resin is 260-277 ° C.

Long term high heat condition shall be avoided to reduce the chance of material degradation. A relatively small increase in screw RPM will result in a large increase in melt temperature, while the control setting does not change. It is recommended to use a hand-held pyrometer to measure the melt temperature. This measurement shall be performed on the thermoplastic melt after the machine has started cycling. The control of mold temperature is very important, so it must be checked regularly. Mold temperature has a great influence on the following parameters: surface appearance, size, shrinkage, warpage, crystallization speed, molding stress, and thermal behavior of injection molded parts.

要使模塑制件获得最佳的光泽度，应使模具表面温度保持在66-93 ° C。冷模具还会导致其它表面缺陷的产生，连枝和条纹，在注塑深颜材料时，更是如此。模具变冷时，还会降低结晶性，并使表面光洁度变差。这两方面因素会产生污斑的负作用。对于像ENDURAN树脂这样的半结晶材料，模具温度高会引起较高等度的模塑结晶，这样，可望得到高收缩量值。另一方面，模具温度太低，会造成模塑后结晶，制件使用时，存在翘曲变形的危险。