

Loton 5420HE

材料简介: Loton 5420HE 是一款阻燃聚碳酸酯材料, 无氯、无溴, 阻燃等级 V0/1.5mm, 具有较高流动性, 加工易成型, 优异加工稳定性, 颜色稳定性, 高耐热高抗冲。

TYPICAL PROPERTIES 典型特性	TYPICAL VALUE 典型值	UNIT 单位	STANDARD 测试标
PHYSICAL 物理性能			准
Melt Flow Rate, 300°C/1.20kgf 熔融指数	18	g/10min	ASTM D1238
Specific Gravity 比重	1.20	/	ASTM D792
MECHANICAL 机械性能			
Tensile Stress, yld, Type I, 50mm/min 屈服强度	55	Mpa	ASTM D638
Tensile Stress, brk, Type I, 50mm/min 断裂强度	60	Mpa	ASTM D638
Tensile Strain, brk, Type I, 50mm/min 断裂伸长率	110	%	ASTM D638
Flexural Stress, yld, 2.0mm/min, 50mm span 弯曲强度	85	Mpa	ASTM D790
Flexural Modulus, 2.0mm/min, 50mm span 弯曲模量	2150	Mpa	ASTM D790
IMPACT 冲击性能			
Izod Impact, notched, 23°C 冲击强度	660	J/m	ASTM D256
FLAME CHARACTERISTICS 燃烧特性			
UL 94 V-0 Flame Class Rating(3)	1.5	mm	UL 94

1) 上述数据是用注塑样条在 23°C, 50% 湿度条件测得; 数据为实验典型值, 不做正式质保承诺。

2) 颜色产品的数据可能略有变化。

1). Typical values only. Variations within normal tolerances are possible for various colors. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection molded samples.

2). Only typical data for material selection purpose. Not to be used for part or tool design.
3). This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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TYPICAL PROPERTIES 典型特性	TYPICAL VALUE 典型值	UNIT 单位	STANDARD 测试标准
THERMAL 热学性能			准
HDT, 0.45MPa, 3.2mm, unannealed	134	°C	ASTM D648
HDT, 1.82MPa, 3.2mm, unannealed	125	°C	ASTM D648
热变形温度			
Vicat Softening Temp, Rate B/50	142	°C	ASTM D1525
维卡软化点温度			

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PROCESSING PARAMETERS 注塑加工参数	TYPICAL VALUE 典型值	UNIT 单位
Injection Molding 注射成型		
Minimum moisture content 含水率	0.02	%
Drying Temperature 干燥温度	100~120	°C
Drying Time 干燥时间	3~4	hrs
Drying Time (Cumulative) 持续干燥时间	8	hrs
Mold shrinkage 成型收缩率	0.4~0.8	%
Melt Temperature 熔融温度	270~310	°C
Nozzle Temperature 喷嘴温度	275~310	°C
Front - Zone 3 Temperature 前段温度	265~300	°C
Middle - Zone 2 Temperature 中段温度	255~285	°C
Rear - Zone 1 Temperature 后段温度	245~260	°C
Mold Temperature 模具温度	70~120	°C
Back Pressure 背压	0.3~0.7	MPa
Screw Speed 螺杆转速	40~70	rpm

以上数值仅供参考，具体要根据产品、注塑机和模具进行适当调整。

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