



Eastech
亿科化学



聚合睿见 塑造无限

临时技术规格书

Provisional Technical Data Sheet

全球领先高性能聚合物材料制造商 & 客户一体化解决方案提供者

亿科化学有限责任公司

www.eastechchemical.com

ABS 产品资料 Product Information

产品牌号 M4

产品特性 Product features

- Matt
- High stretch ratio
- Low roughness for extrusion
- 哑光
- 高拉伸比
- 光滑的挤出表面

产品应用 Applications

- Automotive and transportation
- Extrusion and co-extrusion of sheets
- Furnitures edgebands and surfaces
- 汽车&交通
- 挤出/共挤片材
- 家具封边&表面材料

信息参数 Information parameters

性能 Properties	测试方法 Test Standard	测试条件 Test Condition	单位 Unit	典型值 Typical value ^[1,2]
物理性能 Physical properties				
密度 Density	ISO 1183	23°C	g/cm ³	1.04
熔体质量流动速率 Melt mass-flow rate(MFR)	ISO 1133	220°C/10kg	g/10min	8
机械性能 Mechanical properties(23°C/50% r. h.)				
拉伸屈服强度 Tensile strength at yield	ISO 527	50mm/min	MPa	35
屈服应变 Strain at yield	ISO 527	50mm/min	%	3.4
拉伸模量 Tensile modulus	ISO 527	1mm/min	MPa	1550
洛氏硬度 Rockwell hardness	ISO 2039/2	R Scale	/	97
弯曲强度 Flexural strength	ISO 178	2mm/min	MPa	46
弯曲模量 Flexural modulus	ISO 178	2mm/min	MPa	1500
悬臂梁缺口冲击强度 Izod notched impact strength	ISO 180/1A	23°C, 5.5J	kJ/m ²	10
热性能 Thermal properties				
维卡软化温度 Vicat Softening temperature	ISO 306	50N, 50°C/h	°C	100
模塑收缩率 Molding shrinkage	ISO 294/4	23°C	%	0.4~0.7

[1]数据为典型值，仅供参考，不作为品质指标及其他用途的保证；The data are typical values for reference only and are not used as quality indicators or other purposes;

[2]不同颜色的产品其性能可能会不同。Different colors of products may have different properties.

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建议加工及干燥条件 Recommended processing & Drying conditions

- ❖ 干燥时间 Drying time 2~4h
- ❖ 干燥温度 Drying temperature 80~90℃
- ❖ 干燥设备 Drying equipment 热风式干燥机 Hot air dryer

注塑成型工艺 Injection molding process

相关条件 Related conditions

		典型值 Optimum	范围 Range
熔体温度	Melt Temp.	220℃	210~230℃
料筒温度	Barrel Temp.		
	后段, Rear	210℃	200~220℃
	中段, Middle	215℃	205~225℃
	前段, Front	220℃	210~230℃
	喷嘴, Nozzle	220℃	210~230℃
加工上限温度	Processing Temp. Upper Limit	260℃	
注射压力	Injection Pressure	40~100MPa	
注射速度	Injection Speed	40~80mm/s	
塑化背压	Plasticization Back Pressure	5~20MPa	
建议模具温度	Recommended Mold Temp.	40~80℃	

以上加工参数仅供参考，实际工艺参数应根据不同机型、不同模具以及不同产品等进行适当调整。
The above processing parameters are for reference only. Actual process parameters should be adjusted appropriately according to different models, different molds and different products.

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