

SABIC LEXAN™ PC EM1210物性表

属性	典型值	UNITS	测试手段
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	81	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2030	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	774	J/m	ASTM D256
Izod Impact, notched, -30°C	694	J/m	ASTM D256
Izod Impact, notched, 23°C, 6.4mm	694	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	61	J	ASTM D3763
Instrumented Dart Impact Energy @ peak, -30°C	65	J	ASTM D3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	135	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D648
CTE, -40°C to 95°C, flow	6.48E-05	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.19	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.16	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm	0.5-0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	13	g/10 min	ASTM D1238
Injection Molding			
Drying Temperature	120	°C	
Drying Time	3-4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	

Melt Temperature	295-315	°C
Nozzle Temperature	290-310	°C
Front - Zone 3 Temperature	295-315	°C
Middle - Zone 2 Temperature	280-305	°C
Rear - Zone 1 Temperature	270-295	°C
Mold Temperature	70-95	°C
Back Pressure	0.3-0.7	MPa
Screw Speed	40-70	rpm
Shot to Cylinder Size	40-60	%
Vent Depth	0.025-0.076	mm

此数据由我们从该材料的生产商处获得。我们尽最大努力确保此数据的准确性，但是我们对这些数据值不承担任何责任，并强烈建议在最终选料前，就数据值与材料供应商进行验证。