

WONDERLOY® PC-540NF

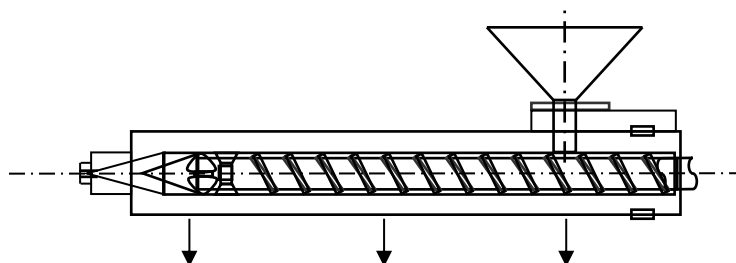
May 6, 2025 V1W

加工建议条件:

A 干燥条件: 80~100°C x 4 hrs

- 与下列条件有关
- a) 环境湿度
 - b) 储存条件
 - c) 干燥机的干燥状况

B. 射出机温度设定建议:



规格		喷嘴	压缩段	进料段	模温 *
PC-540NF	最高 (°C)	250	260	230	40 -80
	最低 (°C)	220	230	200	

- * 随下列条件而变动
- a) 成型品肉厚
 - b) 冷却回路设计
 - c) 浇口、浇道设计

注意事项：

1. 操作期间请避免原料受到任何污染.
2. 避免胶料在料管中高温滞留过久.
3. 一般射出时，为避免胶料劣解，射出温度请勿高于270°C.

清料管建议 (Purging):

热分解性的材料不可用于清除残存余射出机或押出机料管中的WONDERLITE®聚碳酸酯树脂与WONDERLOY® PC/ABS树脂。一般用于PC与PC/ABS的清管剂多为热安定性较佳之树脂，例如聚乙烯Polyethylene (PE)、聚丙烯Polypropylene (PP) ...等，即是广为业者使用的清管材料。

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