



苏州和庚丽塑胶科技有限公司  
Suzhou Hegengli Plastics Technology Co., Ltd.

## PA66 A0C2-TF4 BK

特性：PA66 碳纤增强材料，该材料具有优异的机械性能和耐磨特性。

用途：汽车零部件、机械部件、工程配件、齿轮等。

| 项目<br>Items                                  | 测试标准<br>Standard  | 测试条件<br>Condition | 单位<br>Unit         | 数值<br>Value |
|----------------------------------------------|-------------------|-------------------|--------------------|-------------|
| 物理性能/Physical                                |                   |                   |                    |             |
| 密度/Density                                   | ISO 1183          | 23℃<br>/55%RH     | g/ cm <sup>3</sup> | 1.3         |
| 熔融指数/Melt-Flow Rate                          | ISO 1133          | ℃/KG              | g/10min            | -           |
| 成型收缩率/ Molding Shrinkage                     | ISO 294-4         | Flow              | %                  | 0.3-0.7     |
|                                              |                   | Cross-flow        | %                  | 0.5-0.9     |
| 填充含量/Filler Contents                         | ISO 3451          | 800℃/2H           | %                  | 10          |
| 机械性能/Mechanical                              |                   |                   |                    |             |
| 拉伸强度/Tensile Strength                        | ISO 527-2         | 5mm/min           | Mpa                | 160         |
| 延伸率/Elongation at Break                      | ISO 527-2         | 5mm/min           | %                  | 3.2         |
| 拉伸模量/Tensile Modulus                         | ISO 527-2         | 5mm/min           | Mpa                | 12000       |
| 弯曲强度/Flexural Strength                       | ISO 178           | 2mm/min           | Mpa                | 230         |
| 弯曲模量/Flexural Modulus                        | ISO 178           | 2mm/min           | Mpa                | 9000        |
| 悬臂梁缺口冲击强度<br>Izod Notched Impact Strength    | ISO 180/1A        | 2.75J             | KJ/ M <sup>2</sup> | 10          |
| 悬臂梁无缺口冲击强度<br>Izod Unnotched Impact Strength | ISO 180/1U        | 5.5J              | KJ/ M <sup>2</sup> | 40          |
| 其他性能/Other                                   |                   |                   |                    |             |
| 阻燃性/Flammability                             | UL-94             | 3.0mm             |                    | HB          |
| 阻燃性/Flammability                             | UL-94             | 1.5mm             |                    | HB          |
| 熔点/Melt Point                                | ISO 11357         |                   | ℃                  | 262         |
| 热变形温度/HDT                                    | ISO 75-2          | 0.45Mpa           | ℃                  | 250         |
|                                              |                   | 1.82Mpa           | ℃                  | 235         |
| 灼热丝测试/GWIT                                   | IEC<br>60695-2-13 | 3mm               | ℃                  | -           |
| 漏电起恒指数/CTI                                   | IEC 60112         | 50 滴              | V                  | -           |

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## 注塑工艺

|                                  |          |                          |               |
|----------------------------------|----------|--------------------------|---------------|
| 熔体温度<br>Melt Temperature         |          | ℃                        | 285-315       |
| 料筒温度<br>Barrel Temperature       | 后段       | ℃                        | 270-280       |
|                                  | 中段       | ℃                        | 280-290       |
|                                  | 前段       | ℃                        | 280-300       |
|                                  | 喷嘴       | ℃                        | 300-315       |
| 加工温度上限<br>Processing Temp. Limit |          | ℃                        | <330          |
| 模具温度<br>Mold Temperature         |          | ℃                        | 120-140       |
| 注塑压力<br>Injection Pressure       | 60-90Mpa | 干燥条件<br>Drying Condition | 110-130℃ 4-6H |

### 注意事项:

- 1、以上性能测试数据的测试环境，若非特别指明，均为冷却 24H 后、23℃、55%相对湿度环境
- 2、以上性能数据是该产品的典型数值，仅供参考，不作为产品验收的标准
- 3、染色料的性能可能与以上数值稍有不同
- 4、以上数值仅供注塑机参考使用，可根据不同机型、不同模具以及产品要求，对上述工艺做适当调整.

### Note:

- 1、 All above values tested under the condition as temperature 23℃, 55% humidity and cooling down after 24H.
- 2、 All above values is the typical test results for reference, which should not be used as the acceptable standard of the final mass production goods.
- 3、 The performance of the color material may be slightly different from the above values.
- 4、 All above value are only for injection molding machine use and reference, according to the requirements of different models, different molds and products, the process do appropriate adjustment