



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

注塑工艺

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|----------------------------------|----------|--------------------------|----------------|
| 熔体温度 Melt Temperature | | °C | 260-280 |
| 料筒温度 Barrel Temperature | 后段 | °C | 250-260 |
| | 中段 | °C | 250-270 |
| | 前段 | °C | 260-280 |
| | 喷嘴 | °C | 270-280 |
| 加工温度上限 Processing Temp. Limit | | °C | <300 |
| 模具温度 Mold Temperature | | °C | 100-140 |
| 注塑压力 Injection Pressure | 50-80Mpa | 干燥条件 Drying Condition | 110-130°C 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°C、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 °C, 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