



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

**PA66 A101B1**

**特性：**PA66 树脂 优异的脱模性能。

**用途：**运动器材，工业配件，汽车配件、电子配件等专用料。

| 项目<br>Items                                  | 测试标准<br>Standard | 测试条件<br>Condition | 单位<br>Unit         | 数值<br>Value |
|--|------------------|-------------------|--------------------|-------------|
| <b>物理性能/Physical</b>                         |                  |                   |                    |             |
| 密度/Density                                   | ISO 1183         | 23°C/55%RH        | g/ cm <sup>3</sup> | 1.13        |
| 熔融指数/Melt-Flow Rate                          | ISO 1133         | °C/KG             | g/10min            | -           |
| 成型收缩率/ Molding Shrinkage                     | ISO 294-4        | Flow              | %                  | 0.8-1.3     |
|  |                  | Cross-flow        | %                  | 0.9-1.4     |
| 填充含量/Filler Contents                         |                  | 800°C/2H          | %                  | -           |
| <b>机械性能/Mechanical</b>                       |                  |                   |                    |             |
| 拉伸强度/Tensile Strength                        | ISO 527-2        | 5mm/min           | Mpa                | 75          |
| 延伸率/Elongation at Break                      | ISO 527-2        | 5mm/min           | %                  | 25          |
| 拉伸模量/Tensile Modulus                         | ISO 527-2        | 1mm/min           | Mpa                | 3000        |
| 弯曲强度/Flexural Strength                       | ISO 178          | 2mm/min           | Mpa                | 95          |
| 弯曲模量/Flexural Modulus                        | ISO 178          | 2mm/min           | Mpa                | 2500        |
| 悬臂梁缺口冲击强度<br>Izod Impact, Notched            | ISO 180/1A       | 5.5J              | KJ/ M <sup>2</sup> | 8.5         |
| 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> | -           |
| <b>其他性能/Other</b>                            |                  |                   |                    |             |
| 阻燃性/Flammability                             | UL-94            | 3.2mm             |                    | -           |
| 阻燃性/Flammability                             | UL-94            | 1.6mm             |                    | -           |
| 熔点/Melt Point                                | ISO 11357        |                   | °C                 | 262         |
| 热变形温度/HDT                                    | ISO 75-2         | 0.45Mpa           | °C                 | 190         |
|  |                  | 1.82Mpa           | °C                 | 70          |
| 灼热丝测试/GWIT                                   | IEC 60695-2-13   | 3mm               | °C                 | -           |
| 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         |          | °C                       | 250-270        |
| 料筒温度<br>Barrel Temperature       | 后段       | °C                       | 230-260        |
|                                  | 中段       | °C                       | 250-270        |
|                                  | 前段       | °C                       | 260-290        |
|                                  | 喷嘴       | °C                       | 260-290        |
| 加工温度上限<br>Processing Temp. Limit |          | °C                       | <300           |
| 模具温度<br>Mold Temperature         |          | °C                       | 70-100         |
| 注塑压力<br>Injection Pressure       | 60-90Mpa | 干燥条件<br>Drying Condition | 100—110°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

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