

台化 PP 樹脂射出/押出成形加工條件

| 項目 | 單聚物 Homo Polymer | | | | | 隨意共聚物 Random Copolymer | | 耐衝擊共聚物 Impact Copolymer | | |
|---------------------------|----------------------------------|----------------|---|---|---|--|---|---|---|-------------------------|
| | 押出吹製級 | 扁紗級 | 薄膜級 | 射出級 | 纖維級 | 射出級 | 薄膜級 | 射出級 | 押出級 | |
| 規 格 | T1002 T1202 T2502 B1101 | S1003 S1005 | F2003AR F2003AT F2003AM F2011 F1611 | K1108 K1011 K1023 K1525 K1035 K2038 K2051 K2065 K1060 | S1803 S1023 S1040 S2023 S2123 S2035 S1019 | K4015 K4038 K4502 K4515 K4535 K4635 K4715 K4750 T3002 K4650 | F4002 F4006 F4007 F4008 T4002 | K7005 K7025 K8802 K8003 K8003AN K8005 K8009 K8025 K8050 K8065 K9003 | K9010 K9017 K3004 BC03ZX K3009AN K3009AU KP03B K3029 K7009AH K7005AX | T7002 T8002 B8001 |
| 收縮率(%) | 1.5~1.9 | --- | --- | 1.4~1.8 | --- | 1.5~2.0 | --- | 1.4~1.8 | 1.4~1.8 | |
| 螺桿溫度(°C) | 200~230 | 200~270 | 220~260 | 200~290 | 220~260 | 220~240 | 190~220 | 180~230 | 200~230 | |
| 射出壓力(kg/cm ²) | --- | --- | --- | 80~120 | --- | 40~90 | --- | 30~60 | --- | |
| 模溫(°C) | 190~210 | 280~290 | 230~250 | 30~50 | 220~240 | 30~50 | 220~240 | 30~50 | 190~210 | |
| 鑄模輪 / 冷卻輪水溫(°C) | --- | 30/50~60 | 30/30~40 | --- | 30/50~60 | --- | 30/30 | --- | ---/30~50 | |
| 冷凍輪水溫(°C) | --- | --- | 12~18 | --- | --- | --- | --- | --- | --- | |

備註:最適條件須參照射(押)出機規格、模具、成形品設計及塑料特性之不同而調整



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