

Typical properties of Xydar® MG-350 PRL

Properties	Unit	Method (ASTM)	MG-350 PRL
Tensile strength (3.2mmT) 抗拉强度	MPa	D638	116
Tensile Modules (3.2mmT) 抗张弹性率	GPa		14.6
Elongation (3.2mmT) 抗张伸展率	%		3.0
Flexural strength (3.2mmT) 弯曲强度	MPa	D790	160
Flexural modulus (3.2mmT) 弯曲弹性率	GPa		13.3
Poisson's ratio 泊松比	—	—	0.33
Izod impact strength (Un-notched) Izod 冲击强度 Unnotched - 无缺口	kJ/m^2	D256	42
Rockwell Hardness 洛氏硬度	R Scale	D785	97
Specific gravity 比重	—	D792	1.78
Water absorption 吸水率	%	D570	0.02
Deflection temperature under load (1.82Mpa) 热变形温度(1.82Mpa)	°C	D648	275
Thermal conductivity 导热系数	$\text{kcal/m}\cdot\text{hr}\cdot\text{°C}$	F433	0.310
Flammability rating (V-0 applied thickness) 难燃性 (V-0 取得済み)	mm	UL94	0.30
Oxygen index 氧指数	%	D2863	46
Dielectric strength 耐电强度	kV/mm	D149	34.9
Arc resistance 耐电弧	sec	D495	—

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Properties		Unit	Method (ASTM)	MG-350 PRL
Volume resistivity 体積抵抗率		$X10^{15} \Omega \cdot \text{cm}$	D257	26.0
Surface resistivity 表面抵抗率		$X10^{15} \Omega$		18.5
Dielectric constant 誘電率	10 ² Hz	—	D150	4.2
	10 ⁶ Hz	—		5.2
Dielectric dissipation factor 誘電正接	10 ² Hz	—		0.013
	10 ⁶ Hz	—		0.029

Coefficient of Linear Thermal Expansion (線膨脹係數)

Unit: $10^{-5} \text{cm/cm}^{\circ}\text{C}$

Grade	Direction*	Range of Temperature (溫度範圍) (°C)			
		50-100	100-150	150-200	200-250
MG-350PRL	MD	1.1	1.1	0.9	0.7
	TD	6.1	7.2	8.2	9.2

Direction* : MD= Machine Direction

TD= Transversal Direction

成形品 : 100mm x 100mm x 3mm 平板

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Molding Conditions (成形条件)

成形参数		Unit	MG-350 PRL 成形範囲	MG-350 PRL 推薦条件
温度 Temp [°C]	后段温度	°C	300~320	300
	中段温度	°C	320~350	340
	前段温度	°C	340~360	360
	喷嘴温度	°C	340~360	360
	模具温度	°C	40~120	80~120
射出压力		MPa	30~120	40~80
射出速度		—	中~高速	中~高速
保持压力		MPa	20~80	40~60
背压		MPa	3~10	3~5
初期开模速度		%	10 以下	5
冷却时间		可能範囲内稍長		
干燥条件		Over 150°C; 8~24 hours		

1. 出现流涎时请将喷嘴温度降一些
2. 松退设定过大会较容易卷入空气，请注意
3. 请将残量设低（为防止材料热降解）
4. 冷却时间与计量时间的差较大的情况，推荐设定计量延迟时间
5. 由于固化速度相对较慢，冷却时间请多抓一些，并缓速开模

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