CONFIDENTIAL

The Future of Energy, Resources and Materials
JX Nippon Oil & Energy Corporation
ENEOS

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TYPICAL PROPERTIES OF XYDAR® SF-321

Item	Method (ASTM)	Unit	SF-321
抗拉强度 Tensile strength	D638	MPa	128
抗伸弹性率 Tensile modulus	D638	GPa	—
抗张伸展率 Elongation	D638	%	1.6
弯曲强度 Flexural strength	D790	MPa	165
弯曲弹性率 Flexural modulus	D790	GPa	13.9
Izod 冲擊强度 无缺口 Izod impact strength (unnotched)	D256	kJ/m^2	40
比重 Specific gravity	D792	-	1.63
热变形温度 Deflection temperature under load (load 1.82Mpa)	D648	℃	267
成形收缩率 (成形品 100x100x1mm) Mold shrinkage	-	MD(%) TD(%)	0.08 0.79

- Xydar is the registered trade mark of Solvay Specialty Polymers, USA.
- The data shown in this paper are based on our laboratory data, and not always directly applicable to your products used under different conditions.

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射出成形条件(Molding conditions):

Grade		SF-321	成形開始時 推薦條件
温度 Temp [℃]	后段温度 (Rear)	280~320	300
	中段温度 (Middle)	320~360	355
	前段温度 (Front)	350~370	355
	射嘴温度 Nozzle Temperature (℃)	350~370	355
	模具温度 Mold Temperature (℃)	40~120	80
射出压力 Injection Pressure (MPa)		30~150	—
射出速度 Injection Speed		Medium to high speed	
干燥条件 Drying		Over 130℃; 4~24 hours	

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