



Technical Data Sheet 規格書

Grade 規格	BG002-r
Resin Type 材質種類	Minimum 65% PCR ABS with 20% Glass Fiber Reinforced
Color 顏色	Black
Revision Date 修改日期	2024/6/16 Rev. 3

檢驗項目 Property	測試標準 Standard	測試條件 Test Condition	實際測值 Typical Value	範圍 Range	單位 Unit
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Physical 物理性質

比重 Specific Gravity	ASTM D792	23°C	1.180	1.170-1.210	g/cm ³
收縮率 Molding Shrinkage	ASTM D955	23°C	-	0.2-0.4	%
熔融指數 Melt Flow Rate	ASTM D1238	240°C, 10kg	22.0	18.0-28.0	g/10min

Mechanical 機械性質

衝擊強度 IZOD Impact Strength, Notched	ASTM D256	3.2mm, 23°C	6.5	5.0-10.0	kg-cm/cm
彎曲強度 Flexural Strength	ASTM D790	3.2mm, 2.0mm/min Span 50mm	1,050	1,000-1,500	kg/cm ²
彎曲模數 Flexural Modulus	ASTM D790	3.2mm, 2.0mm/min Span 50mm	55,000	50,000-65,000	kg/cm ²
斷裂伸長率 Elongation at break	ASTM D638	3.2mm 5mm/min	6	4-10	%
拉伸強度 Tensile Strength	ASTM D638	3.2mm 5mm/min	620	600-1,000	kg/cm ²

Thermal 熱性質

熱變形溫度 H.D.T.	ASTM D648	1.8MPa, 3.2mm unannealed	92	90-100	°C
		1.8MPa, 3.2mm annealed (80°C/2hrs)	98	95-105	

Flammability 耐燃性

阻燃等級 Flame Rating	UL94	1.5mm	HB	-	-
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Note 注意事項

- Typical values are only for material selction purpose, and variation within normal tolerances are for various lots.
- Values given should not be used for part or tool design. Users should confirm results by their own tests.

Processing Guide 加工條件參考

Grade 規格	PCR ABS+20%GF BG002-r
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檢驗項目 Property	參考範圍 Range	單位 Unit
預乾燥溫度 Pre-Dry Temperature	75-85	°C
預乾燥時間 Pre-Dry Time	2-4	hrs
熔融溫度 Melt Temperature	240-270	°C
料管後段溫度 Rear Temperature	245-250	°C
料管中段溫度 Middle Temperature	250-255	°C
料管前段溫度 Front Temperature	250-255	°C
射嘴溫度 Nozzle Temperature	255-260	°C
模溫 Mold Temperature	50-80	°C
射出速度 Injection Speed	40-90	%

Note 注意事項

1. Please avoid using "Cleaning Naphtha 去漬油/去脂水" for cleaning work to prevent the unexpected issues.
2. Cylinder temperatures are valid for a standard 3-zone barrel.
3. Temperature set-up for different barrel types may change according to configuration.
4. Drying conditions are for dry air dryers only.
5. Drying times and drying temperatures may differ depending on valid dryer type.