



東永國際有限公司

Eastern Ever International Co., Ltd

Technical Data Sheet 規格書

Grade 規格	PAR75
Resin Type 材質種類	Minimum 75% PCR PC/ABS
Color 顏色	White and Light Colors
Revision Date 修改日期	2023/4/28 Rev. 1

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	1.195	1.170-1.20	g/cm ³
收縮率 Molding Shrinkage	ASTM D955	23°C	-	0.4-0.7	%
熔融指數 Melt Flow Rate	ASTM D1238	260°C, 2.16kg	40.0	35.0-45.0	g/10min

Mechanical 機械性質

衝擊強度 IZOD Impact Strength, Notched	ASTM D256	3.2mm, 23°C	42.5	40.0-65.0	kg-cm/cm
彎曲強度 Flexural Strength	ASTM D790	6.4mm, 2.8mm/min Span 100mm	780	700-1,000	kg/cm ²
		3.2mm, 1.3mm/min Span 50mm	1,000	800-1,100	
彎曲模數 Flexural Modulus	ASTM D790	6.4mm, 2.8mm/min Span 100mm	20,200	19,000-23,000	kg/cm ²
		3.2mm, 1.3mm/min Span 50mm	30,000	28,000-32,000	
拉伸強度 Tensile Strength	ASTM D638	3.2mm 50mm/min	500	450-600	kg/cm ²

Thermal 熱性質

熱變形溫度 HDT	ASTM D648	1.8MPa, 6.4mm Unannealed	90	80-90	°C
		1.8MPa, 6.4mm Annealed (80°C/2hrs)	98	90-100	
		1.8MPa, 3.2mm Unannealed	84	80-90	
		1.8MPa, 3.2mm Annealed (80°C/2hrs)	91	90-100	

Flammability 耐燃性

阻燃等級 Flame Rating	UL94	1.5mm	5VB V0	-	-
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Note 注意事項

1. Typical values are only for material selction purpose, and variation within normal tolerances are for various lots.
2. 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 PCABS PAR75, for all recycle ratio, all colors
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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	80-90	°C
預乾燥時間 Pre-Dry Time	3-4	hrs
熔融溫度 Melt Temperature	245-275	°C
料管後段溫度 Rear Temperature	230-260	°C
料管中段溫度 Middle Temperature	235-270	°C
料管前段溫度 Front Temperature	245-275	°C
射嘴溫度 Nozzle Temperature	240-270	°C
模溫 Mold Temperature	60-95	°C

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.