



技術資料表  
Technical Data Sheet

**DGRTYPE**

耐衝擊、耐低溫耐寒，剛性強化，低尺寸收縮

Impact resistance, low temperature and cold resistance,  
rigidity enhancement, low dimensional shrinkage

樹脂 Resin PA6 Polyamide6

規格 Grade DGR53-C9

來源 source 上禾伸企業

描述 Description

■優良的耐低溫特性，耐寒-20°C佳，與常溫耐衝擊性。

Excellent low temperature resistance, good cold resistance -20 °C, and impact resistance at room temperature.

■尺寸安定，收縮率低。耐化學性、耐油性佳。

Stable size and low shrinkage. Good chemical resistance and oil resistance.

■耐磨耗，耐刮擦，表面平滑。耐彎曲、反撥彈性佳。

Wear-resistant, scratch-resistant, smooth surface. Bending resistance, good rebound elasticity.

■成型容易、快速，脫模週期短。

Forming is easy and fast, and the demolding cycle is short.

■添加 15%無機性礦粉，剛性、耐熱強化。

Add 15% inorganic mineral powder to strengthen rigidity and heat resistance.

用途 Use :

運動器材:雪靴、溜冰鞋、直排輪、自行車零配件。

Sports equipment: snow boots, roller skates, inline rollers, bicycle spare parts.

保護安全用品:護目鏡架、護膝、護肘、護襠。

Protective safety supplies: goggle holder, knee pads, elbow pads, crotch pads.

傢俱用品零件:椅腳、椅輪、減震用品。

Furniture parts: chair legs, chair wheels, shock absorbers.

電動工具、五金用品、機械零配件、嬰兒車用品、動態零件。

Power tools, hardware supplies, mechanical spare parts, baby carriage supplies, dynamic parts.



**成型模式**

**Forming mode**

射出成型

Injection Molding

**特性 Properties**

項目 Project	單位 Unit	測試標準 Testing standards	標準數值 Typical Value
填充劑含量 Filler Content	%		15
比重 Specific Gravity	g/cm <sup>3</sup>	ASTM D792	1.20
流動指數 MFR,(MI) 275×2.16KG	g/10min	ASTM D1238	10.0
收縮率-平行∥ Mold Shrinkage MD	%	3 mm t	0.3
收縮率-垂直⊥ Mold Shrinkage TD			~0.8
耐燃性 Flammability		UL-94	HB
顏色 Color			natural color

**機械特性 Mechanical properties**

伸張降伏強度 Tensile Strength at Yield			1120
伸張斷裂強度 Tensile Strength at Break	kg/ cm <sup>2</sup>	ASTM D638	880
拉伸彈性係數 Tensile Modulus			44300
斷裂伸張率 Tensile Elongation at Break	%		6.0
彎曲強度 Flexural Strength	kg/ cm <sup>2</sup>	ASTM D790	1720
彎曲模數 Flexural Modulus			44900
衝擊強度(缺口式)IZOD Impact (notched)	23°C kg-cm/cm	ASTM D256	20.0
硬度 Rockwell/Shore Hardness	D	ASTM D2240	78

**熱力特性 Heat properties**

熱變型溫度 18.54kg/ cm <sup>2</sup> H D T	°C	ASTM D648	150
熱變型溫度 4.6kg/ cm <sup>2</sup> H D T			180
塑料狀態 plastic state			乾燥 dry

**成型條件 Molding conditions**

烘乾溫度 Drying temp. °C	100	烘乾時間 Drying time H	4
進料區溫度 Feed zone temp. °C	210~225	壓縮區溫度 Compression zone temp. °C	220~235
計量區溫度 Metering zone temp. °C	225~245	噴嘴溫度 Nozzle temp. °C	225~255
模具溫度 Mold temp. °C	85	射出壓力 Injection pressure Kg/ cm <sup>2</sup>	450~1300

\*雖然上述信息是出於善意並被認為是準確的，但我們不保證依賴此類信息取得令人滿意的結果，並且不承擔因使用此類信息而引起的任何損失或損害的全部責任。\*以上數值係僅供選擇用途品級之參考。

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DATE : February2022

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