技 術 資 料 表
Technical Data Sheet

BC TYPE

PC/ABS 合金系列共 2 格規格，高耐溫、高耐衝擊，外觀出色，尺寸安定，容易加工

The PC/ABS alloy series comes in two specifications, featuring high temperature resistance, high impact resistance, excellent appearance, dimensional stability, and ease of processing

樹酯 Resin	**PC/ABS** PC/ABS alloy
規格 Grade	BC77-F45D BC77-F4D
來源 source	上禾伸企業 SHANG HE SHEN ENTERPRISE CO., Ltd.

描述 Description

■耐寒性佳，低溫-30℃耐衝擊性優秀，可以在更低溫環境中使用，依然耐衝擊性優秀。
It has good cold resistance and excellent impact resistance at low temperature of -30℃. It can be used in lower temperature environment and still has excellent impact resistance.

■耐熱性高，熱變形溫度 HDT 104~110℃。
It has high heat resistance, with a heat distortion temperature (HDT) of 104~110℃.

■高尺寸精度和穩定性，良好的塗覆性、用於汽車內飾揮發性氣體含量低。
High dimensional accuracy and stability, good coatability, and low volatile gas content for use in automotive interiors.

■合金塑料出色的外觀，表面光亮，製作在外觀產品上，價值感高。
Alloy plastic has an excellent appearance and a glossy surface, which enhances the perceived value of products.

■出色的平衡物性、良好的抗蠕變性、高流動性，容易加工生產。
It has excellent balanced physical properties, good creep resistance, high fluidity, and is easy to process and produce.

成型模式	射出成型
Forming mode	Injection Molding

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特性 Properties

PC/ABS 合金系列 PC/ABS Alloy Series	BC77-F45D	BC77-F4D
項目 Project 測試標準 Testing standards/單 位 Unit /	標準數值 Typical Value	
比重 Specific Gravity ASTM D79 / g/cm³	1.12	1.13
流動指數 MFR,(MI) 260×5KG ASTM D1238 / g/10min	20	19
收縮率-平行 ‖ Mold Shrinkage MD 收縮率-垂直 ⊥ Mold Shrinkage TD 3 mm t / % /	0.4 ~0.6	0.4 ~0.6
耐燃性 Flammability	HB	HB
顏色 Color	Natural color	Natural color
機械特性 Mechanical properties		
伸張降伏強度 Tensile Strength at Yield ASTM D638 / kg/ cm²	560	590
伸張斷裂強度 Tensile Strength at Break ASTM D638 / kg/ cm²	440	460
斷裂伸張率 Tensile Elongation at Break ASTM D638 / %	25	20
彎曲強度 Flexural Strength ASTM D790 / kg/ cm²	920	930
彎曲模數 Flexural Modulus ASTM D790 / kg/ cm²	23500	24000
衝擊強度(缺口式)IZOD Impact (notched) ASTM D256 / 23℃ kg-cm/cm	58	62
硬度 Rockwell/Shore Hardness ASTM D785 / D2240 / D	75	76
熱力特性 Heat properties		
熱變型溫度 18.6kg/ cm² H D T ASTM D648 / ℃	104	110

成型條件 Molding conditions

烘乾溫度 Drying temp. ℃	100~110	烘乾時間 Drying time H	3~4
進料區溫度 Feed zone temp. ℃	220-250	壓縮區溫度 Compression zone temp. ℃	240-270
計量區溫度 Metering zone temp. ℃	240-270	噴嘴溫度 Nozzle temp. ℃	230-270
模具溫度 Mold temp. ℃	70~90	射出壓力 Injection pressure Kg/ cm²	**

*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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