

物理形态和储存

The product is supplied in the form of granules with a bulk density of approx. 0.7 g/cm³. Standard packs are bag and bulk container (octagonal IBC=intermediate bulk container made from corrugated board with a liner bag). Other packaging materials and shipping in road or rail silo wagons are possible by agreement. The containers should only be opened immediately before processing or drying. To ensure that the delivered product absorbs as little moisture as possible, the containers should be stored in dry rooms and always carefully closed again after partial quantities have been withdrawn. In principle, the product can be stored for a long period of time. Containers stored in cold rooms should be equalized to ambient temperature before opening in order to avoid condensation on the granules. Regardless of the storage conditions, the product should be pre-dried according to our recommendations and the machine should preferably be loaded using a closed conveyor system.

安全

如果在推荐的条件下进行加工（参见加工数据表），熔体是热稳定的，不会因分子降解或气体和蒸汽的释放而产生危害。像所有热塑性聚合物一样，产品在过度的热负荷下分解，例如过热或通过燃烧进行清洁时。更多信息可从安全数据表中获得。

注

本资料内容基于本公司目前掌握的知识 and 经验。
由于存在很多因素可能影响我们产品的应用和加工，因此本公司不排除用户进行试验研究的必要。
本资料也不保证具体应用的适应性或某些性能的可靠性。这里的任何描述、图纸、照片、数据、大小、重量等可能不事先通知而更改，但不包括已经达成一致。我们产品的使用者应确保遵守所有权及现有的法律法规。

有关BASF产品有效性，请联系我们或我们的销售代理。

	测试方法	单位	代表值
特征			
树脂缩写	-	-	PA9T-GF30 FR(40)
密度	ISO 1183	kg/m ³	1440
熔体体积流动速度 MVR 325 ° C/5 kg	ISO 1133	cm ³ /10min	30
Drying			
Moisture, recommended ¹⁾	-	%	0.05
预处理/后处理, 预干燥, 温度 ²⁾	-	°C	120
预处理/后处理, 预干燥, 时间 ³⁾	-	h	8
注塑			
注塑, 熔体温度, range	-	°C	310 - 340
注塑, 熔体温度, recommended	-	°C	330
注塑, 模具温度, range	-	°C	100 - 160
注塑, 模具温度, recommended	-	°C	140
注塑, 保压时间, 热塑性塑料	-	min	5
Machine Settings Injection Molding			
注塑, 料斗温度	-	°C	80
注塑, 料筒温度1 (喂料区)	-	°C	310
注塑, 料筒温度2 (压缩区)	-	°C	315
注塑, 料筒温度3 (计量区)	-	°C	320
注塑, 料筒温度4 (模头)	-	°C	325
Shrinkage			
成型收缩率(平行)	ISO 294-4	%	0.35
成型收缩率(垂直)	ISO 294-4	%	0.95

注

1) A slight increase in viscosity during processing is possible.

2) Dry air dryer; drying time is dependent on the initial moisture content of the granules, drying temperature and the dew point of the dried air.

3) In case of improper storage (e.g. open packages) drying time may have to be extended.

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