



Globalene 652R-5 (Provisional)

Polypropylene Advanced Material 聚丙烯改性材料

Features 特性: Post-Consumer Recycled Polypropylene Added 50wt.% 添加消費後回收規格之聚丙烯	Typical Application 一般應用: - Non-food Contact Packaging 非食品接觸包材 - Injection Molding 射出成型		
Typical Properties	Test Method	Unit	Value
一般性質	測試方法	單位	數值
Melt flow rate 熔融流動指數 2.16 kg@230℃	ASTM D1238L	g/10min.	13
Density 密度	ASTM D792	g/cm ³	0.91
Tensile strength @ yield 降伏點抗張強度	ASTM D638	Kg/cm ²	348
Tensile elongation @ yield 降伏點抗張伸長率	ASTM D638	%	9.1
Flexural modulus 彎曲彈性係數	ASTM D790	Kg/cm ²	16400
Rockwell Hardness 洛氏硬度	ASTM D785	R Scale	97
Izod impact strength, notched, 23℃ 艾氏衝擊強度, 切口	ASTM D256	kg-cm/cm	3.1

Packing 包裝： 25kg/pk

Storage and Handling 儲放與處置

The inspected and qualified PP pellets will have a shelf life of minimum two years which is estimated from production date, if it is stored at LCY's best condition of proper temperature below 40℃, adequate humidity below 80%, complete package and indoor warehouse with specific protection from damage. However customers might not fully follow the recommendation to conduct the optimal storage condition, the shelf life is recommended six months only at customer site as received.

本公司所生產聚丙烯(塑膠粒)經首次產品驗證程序確認品質後，在適合的溫度(低於 40℃)、適當的濕度(低於 80%)、包裝袋完整、且具有防護設備的倉庫儲存下，其有效使用期限至少 2 年(以製造日期起算)。考量客戶端的儲存條件可能無法完全依照本公司建議來執行，客戶在購入聚丙烯產品(塑膠粒)後，保存期限建議最高為 6 個月。

加工 PROCESSING

652R-5 為聚丙烯，可在常規熱塑性設備上通過射出成型和押出加工。該產品在大多數應用中具有較寬的加工窗口，熔體溫度範圍從 170°C 到 220°C。射出模具須適度控溫在 40~60°C，**建議是 60°C**。

射出試片在物性檢測前，須於有溫度濕度控制(<50%相對濕度)的冷氣實驗室內進行**靜置至少>40hrs，建議是>64hrs**。

652R-5 is polypropylene, which can be processed on conventional thermoplastic equipment by injection molding and extrusion. This product has a wide processing window in most applications with melt temperatures ranged from 170°C to 220°C. The temperature of the mold must be moderately controlled at 40~60°C, and the recommended temperature is **60°C**. The injection molded specimens must be kept in an air-conditioned laboratory with temperature and humidity(<50%RH) control for **at least >40hrs, and >64hrs is recommended before physical properties testing**.

1. 加工溫度與條件 Processing temperature and condition

射出成型 INJECTION MOLDING CONDITIONS		
融體溫度 Melt Temperature		170-220°C
Barrel Temperatures –	Rear (Feed)	170-180°C
	Middle	170-190°C
	Front	180-210°C
	Nozzle	180-220°C
Injection Pressure	: 700-1000 psi (4.8-6.9 MPa) (49-70 kg/cm²)	
Holding Pressure	: 300-600 psi (2.1-4.1 MPa) (21-42 kg/cm²)	
Holding Time	: 4-10 seconds	
Cooling Time	: 15-30 seconds	
Mold Temperature	40-60°C	
Screw Speed	80-200 RPM	
Vent Depth	0.001 inch	
Back Pressure	10-150 psi (0.7-10.5 kg/cm²)	

押出成型 EXTRUSION CONDITIONS		
融體溫度 Melt Temperature		170-220°C
Barrel Temperatures -	Zone 1 (Feed)	170°C
	Zone 2	170°C
	Zone 3 (Transition)	180°C
	Zone 4 (Metering)	190°C
	Zone 5 (Front)	190°C
	Die	190-220°C
Roll Temperature	20-50°C	
Screen Pack	20 to 60 mesh	
Screw	General Purpose 3:1 Compression ratio	≥ 24:1 L/D ratio