



Globalene SJ2202 (Provisional)

Polypropylene Composites 聚丙烯複合材料

Features 特性:

- Random Copolymer Base 無規共聚
- Good Melt Flow Rate 流動性佳
- Renewable Bio-base Blend 再生生質材料混煉
- 25% Starch-base Biopolymer 生質含量 25%

Typical Application 一般應用:

- Consumer Goods 消費性產品
- 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°C	ASTM D1238L	g/10min.	18
Density 密度	ASTM D792	g/cm ³	0.99
Tensile strength @ yield 降伏點抗張強度	ASTM D638	Kg/cm ²	270
Tensile elongation @ yield 降伏點抗張伸長率	ASTM D638	%	10
Flexural modulus 彎曲彈性係數	ASTM D790	Kg/cm ²	10000
Rockwell Hardness 洛氏硬度	ASTM D785	R Scale	82
Izod Impact Strength notched@23C 艾氏衝擊強度	ASTM D256	Kg-cm/cm	3.0

Packing 包裝： 25kg/pk

Product Stewardship Information 產品責任資訊

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加工 PROCESSING

1. 預先烘乾 Pre-drying

產品含澱粉基生質高分子容易吸收水氣，開袋後必須儘快使用，若未使用完請封住袋口並於下次使用前進行70C~90C烘乾。

產品射出若因含水率影響表面品質，強烈建議使用前須進行溫度70~80°C-2小時或90°C-1小時的預先乾燥程序。

The product including starch-base biopolymer will absorb moisture after opening the bag, so it must be used as soon as possible. If it is not used up, please seal the bag and dry it at 70C~90C before next use.

It is strongly recommended to have pre-drying before processing, to avoid the moisture content affects the surface quality of product. The suitable drying conditions are 70~80°C for 2hrs or 90°C for 1hr.

2. 加工溫度 Processing temperature

加工溫度勿超過230°C，為防止澱粉基生質高分子較明顯的黃變。

The processing temperature should not exceed 230°C, to avoid the starch-based biopolymer obvious yellowing.

射出成型 INJECTION MOLDING CONDITIONS

融體溫度 Melt Temperature	160-220°C
Barrel Temperatures – Rear (Feed)	160-180°C
Middle	170-190°C
Front	180-210°C
Nozzle	180-220°C
Injection Pressure	: 700-1000 psi (4.8-6.9 MPa)
Holding Pressure	: 300-600 psi (2.1-4.1 MPa)
Holding Time	: 4-10 seconds
Cooling Time	: 15-30 seconds
Mold Temperature	30-55°C
Screw Speed	100-200 RPM
Vent Depth	0.001 inch
Back Pressure	10-150 psi

押出成型 EXTRUSION CONDITIONS

融體溫度 Melt Temperature	160-220°C
Barrel Temperatures - Zone 1 (Feed)	160°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	60 to 120 mesh
Screw	General Purpose 3:1 Compression ratio ≥ 24:1 L/D ratio

