

# 台化 PP 樹脂射出/押出成形加工條件

| 項目                        | 單聚物<br>Homo Polymer |          |          |         |          | 隨意共聚合物<br>Random Copolymer |         | 耐衝擊共聚合物<br>Impact Copolymer |           |       |
|---------------------------|---------------------|----------|----------|---------|----------|----------------------------|---------|-----------------------------|-----------|-------|
|                           | 押出吹製級               | 扁紗級      | 薄膜級      | 射出級     | 纖維級      | 射出級                        | 薄膜級     | 射出級                         | 押出級       |       |
| 規 格                       | T1002               | S1003    | F2003AR  | K1108   | S1803    | K4015                      | F4002   | K7005                       | K9010     | T7002 |
|                           | T1202               | S1005    | F2003AT  | K1011   | S1023    | K4038                      | F4007   | K7025                       | K9017     | T8002 |
|                           | T2502               |          | F2003AM  | K1023   | S1040    | K4502                      | F4008   | K8802                       | K3004     | B8001 |
|                           | B1101               |          | F2011    | K1525   | S2023    | K4515                      | T4002   | K8003                       | BC03ZX    |       |
|                           |                     |          | F1611    | K1035   | S2123    | K4535                      |         | K8005                       | K3009AN   |       |
|                           |                     |          |          | K2038   | S2035    | K4635                      |         | K8009                       | K3009AU   |       |
|                           |                     |          |          | K2051   | S1019    | K4715                      |         | K8025                       | KP03B     |       |
|                           |                     |          |          | K2065   |          | T3002                      |         | K8050                       | K3029     |       |
|                           |                     |          |          | K1060   |          | K4650                      |         | K8065                       | K7009AH   |       |
|                           |                     |          |          |         |          |                            |         | K9003                       | K7005AX   |       |
| 收縮率(%)                    | 1.5~1.9             | ---      | ---      | 1.4~1.8 | ---      | 1.5~2.0                    | ---     | 1.4~1.8                     | 1.4~1.8   |       |
| 螺桿溫度 (℃)                  | 200~230             | 200~270  | 220~260  | 200~290 | 220~260  | 220~240                    | 190~220 | 180~230                     | 200~230   |       |
| 射出壓力(kg/cm <sup>2</sup> ) | ---                 | ---      | ---      | 80~120  | ---      | 40~90                      | ---     | 30~60                       | ---       |       |
| 模溫 (℃)                    | 190~210             | 280~290  | 230~250  | 30~50   | 220~240  | 30~50                      | 220~240 | 30~50                       | 190~210   |       |
| 鑄模輪 /<br>冷卻輪水溫 (℃)        | ---                 | 30/50~60 | 30/30~40 | ---     | 30/50~60 | ---                        | 30/30   | ---                         | ---/30~50 |       |
| 冷凍輪水溫 (℃)                 | ---                 | ---      | 12~18    | ---     | ---      | ---                        | ---     | ---                         | ---       |       |

備註:最適條件須參照射(押)出機規格、模具、成形品設計及塑料特性之不同而調整



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