

Technical Data Sheet

V-MTECK® Zenith PA/AB Series

Version: V2.0

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RD Center . Nanjing MTeck Co. LTD

Zenith Series Material Datasheet Summary

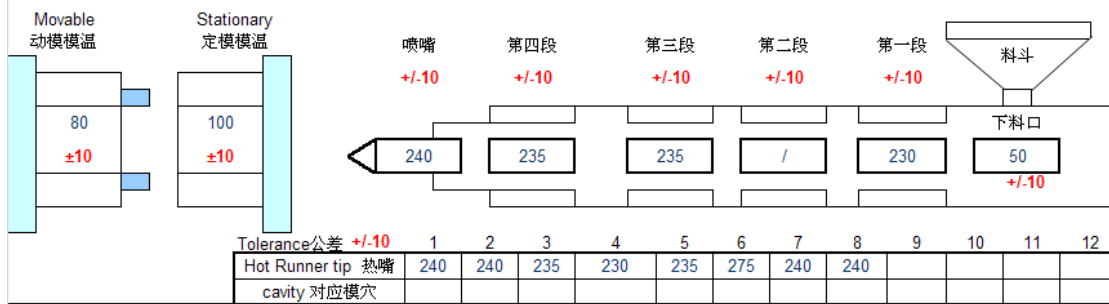
item	unit	standard	condition	Zenith PA10	Zenith AB10
Density	kg/cm ³	ASTM D792	23℃	1.280	1.12
Module	Kg/cm ²	ASTM D790	23℃	2093	2400
Strength	Kg/cm ²		23℃	78	80
IZOD Impact	Kg-cm/cm	ASTM D256	1/8"	66	16
Shrinkage	%	ASDM D955		0. 4-0. 6	0. 3-0. 6
CET	× 10 ⁻⁵ CM/CM/℃	ASTM D696	40-100℃	6-8	6-8
Flamibility	-	UL 94	-	HB (1.50mm)	HB (1.50mm)

Pre-Drying

Material	Temp	Tlme	Holding time	Remark
Zenith PA10(PC/ABS)	105℃-115℃	4-6HrS	< 3 HRS,<105	
Zenith AB10 (ABS)	80℃-85℃	4-6HrS	<3 HRS,<80	

Injection

Zenith AB10注塑标准成型条件 Standard Parameter of Injection Molding



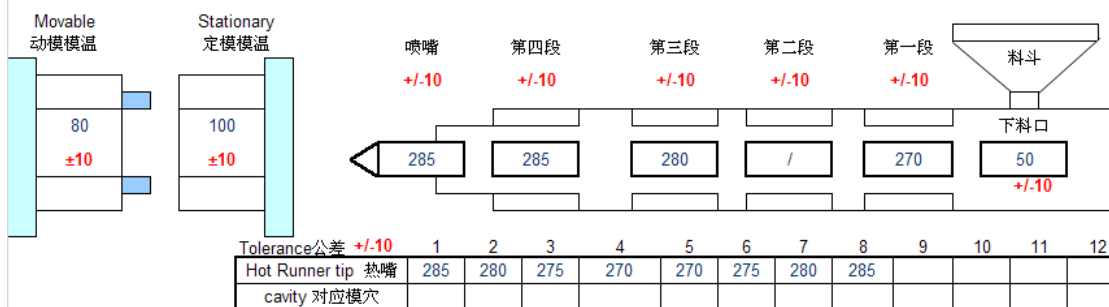
Injection 射出									射出压力 kgf/cm^2 injection pressure
V-P	7	6	5	4	3	2	1		
Stroke行程 $\pm 3 \text{ mm}$	17.5					33	55		1200 ± 200
speed射速 $\pm 10 \text{ mm/s}$					15	30	150		射出时间 S injection time 3 ± 0.2

周期 cycle time	
22.9	S $\pm 0.3 \text{ S}$

Holding pressure 保压					
Holding time S	5	4	3	2	1
保压时间 ± 0.2				0.8	0.5
Holding pressure kgf/cm^2				750	1200
保压压力 ± 200					
Holding speed mm/s	35				
保压速度 $\pm 10\%$					
		Cooling Time S		10	
		冷却时间 $\pm 0.3 \text{ S}$			

Metering 计量	1	2	减压距离 pull-backdis
Metering Stroke 计量行程 $\pm 3 \text{ mm}$	75	80	mm
Rotation Speed 计量转速 rpm	250	100	减压速度 pull-back sp.
BackPres. 背压 $\pm 10 \text{ kgf/cm}^2$	110	80	mm/s

Zenith PA10注塑标准成型条件 Standard Parameter of Injection Molding



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BackPres. 背压 $\pm 10 \text{ kgf/cm}^2$	110	80	mm/s

All the data here for reference! Which can be adjusted on the injection machine .

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