TECHNICAL DATASHEET

TRIREX® 3025GR10

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.20
Water Absorption (24 hours at 23℃)	%	D570	0.15
Melt Flow Rate (300℃, 1.2kg)	g/10min	D1238	14
MECHANICAL			
Tensile Strength at yield	$kg_f/㎠$	D638	600
Tensile Elongation at break	%	D638	180
Flexural Strength at yield	$kg_f/㎠$	D790	950
Flexural Modulus	$kg_f/㎠$	D790	22,000
Izod Impact Strength, notched, 23℃ (1/8")	$kg_f·㎝/㎝$	D256	80
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 ㎏f/㎠	℃	D648	132
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	V-0
Mold Shrinkage (3mm thickness)	%	D955	0.5~0.7

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRIREX® 3025GR10 GRADE

PC

- General processing conditions for TRIREX3025GR10 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	280~300
Nozzle Temperature	℃	280~300
Front Temperature	℃	270~290
Middle Temperature	℃	260~280
Rear Temperature	℃	260~280
Mold Temperature	℃	60~80
Back Pressure	MPa	0.4~0.6
Screw Speed	rpm	50~70
Vent Depth	mm	0.02~0.08
Injection Pressure	MPa	70~140
Injection Speed	%	50~80
Hold Pressure	MPa	35~60
Injection Cushion	mm	3~6

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