TECHNICAL DATASHEET

TRILOY® 540

PC/ASA

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.16
Water Absorption (24 hours at 23℃)	%	D570	0.2
Melt Flow Rate (260℃, 5kg)	g/10min	D1238	8
MECHANICAL			
Tensile Strength at yield	$kg_f/㎠$	D638	350
Tensile Elongation at break	%	D638	60
Flexural Strength at yield	$kg_f/㎠$	D790	500
Flexural Modulus	$kg_f/㎠$	D790	16,000
Izod Impact Strength, notched, 23℃ (1/8")	$kg_f·㎝/㎝$	D256	30
Rockwell Hardness	R scale	D785	117
THERMAL			
HDT, 18.6 kgf/㎠	℃	D648	100
ELECTRICAL			
OTHERS			
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

TRILOY® 540 GRADE

PC/ASA

- General processing conditions for TRILOY540 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	100~110
Drying Time	hr	4~6
Moisture Content, Max	%	0.02
Melt Temperature	℃	260~270
Nozzle Temperature	℃	260~270
Front Temperature	℃	260~270
Middle Temperature	℃	260~270
Rear Temperature	℃	250~260
Mold Temperature	℃	80~110

Global Network

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