Dayson Polymers, LLC

TRIREX® POLYCARBONATE 3027 High Viscosity

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Density – Specific Gravity	sp gr 23/23°C	1.20	ASTM 792
Melt Flow Rate	(230°C/3.8 kg – I)	23 g/10min	ASTM D1238
Mold Shrink, Linear-Flow (0.118in)	in/in	0.0050 to 0.0070	ASTM 955
Water Absorption @ 24 hours	%	.15	ASTM D570
Mechanical			
Tensile Strength		10,200 psi	ASTM D638
Tensile Elongation @ Break	%	120	ASTM D638
Flexural Modulus		284,467 psi	ASTM D790
Flexural Strength		12,800 psi	ASTM D790
Impact			
Notched Izod Impact (0.125in)	ft-lb/in	17.45	ASTM D256
Hardness			
Rockwell Hardness	R-Scale	120	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed		277 °F	ASTM D648
DTUL @ 66 psi - Unannealed		297 °F	ASTM D648
CLTE, Flow	in/in/°F	3.1E-005	ASTM D696
Electrical			
Volume Resistivity		4.0E+016 ohm-cm	ASTM D257
Dielectric Strength	V/mil	762	ASTM D149
Dielectric Constant	1000000 Hz	2.850	ASTM D150
Dissipation Factor	1000000 Hz	0.0092	ASTM D150
Ignition Characteristics			
Flame Rating – UL (0.0625in)		V-2	UL94

PROCESSING INFORMATION

INJECTION MOLDING PARAMETERS	NOMINAL VALUES (ENGLISH)
DRYING TEMPERATURE	248 °F
DRYING TIME	6.0 HR
REAR TEMPERATURE	464 to 536 °F
MIDDLE TEMPERATURE	518 to 590 °F
FRONT TEMPERATURE	518 to 590 °F
NOZZLE TEMPERATURE	518 to 572 °F
PROCESSING (MELT) TEMP	518 to 590 °F
MOLD TEMPERATURE	158 to 230 °F
INJECTION PRESSURE	11400 to 19900 psi

HIGH VISCOSITY
CAMERA, LIGHT COVER
***HF: High Flow, IR: Ice Clear and Releasing Agent, U: UV-Stabilized,**
***-02: Blue Tinted Grade**

Remark: The values presented on the above are typical laboratory averages. All data generated is based on natural material.