

TRIEX SO4-3025UPNV

Polycarbonate Resin

Product Information

TYPICAL DATA OF TRIEX SO4-3025UPNV GRADE

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.20
Water Absorption (24 hours at 23°C)	%	D570	0.15
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	7
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	560
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kg _f /cm ²	D638	850
Flexural Modulus	kg _f /cm ²	D1004	20,200
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	75
-30°C (1/8")	kg _f ·cm/cm	D256	66
-40°C (1/8")	kg _f ·cm/cm	D256	43
-50°C (1/8")	kg _f ·cm/cm	D256	25
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	126
OTHERS			
UL-94 Flammability(1.5mm thickness)	-	(UL 94)	V-0
Mold Shrinkage	%	D955	0.4~0.8

※ 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 FOR TRIEX SO4-3025UPNV GRADE

- General processing conditions for TRIEX SO4-3025UPNV are shown below.
- Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	120
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	°C	280~300
Nozzle Temperature	°C	270~310
Front Temperature	°C	280~310
Middle Temperature	°C	270~290
Rear Temperature	°C	260~280
Mold Temperature	°C	65~105
Back Pressure	MPa	0.4~0.7
Screw Speed	%	40~70(slow to moderate)
Vent Depth	mm	0.02~0.08