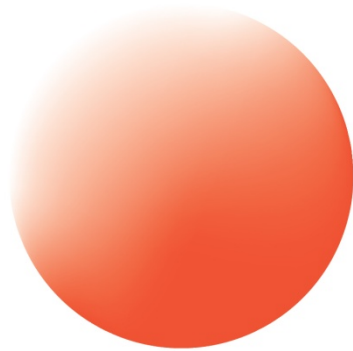


Product Information

TRAMID[®] 923G25

Polyamide resin



TYPICAL DATA OF TRAMID 923G25 GRADE

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.33
Water Absorption (24 hours at 23°C)	%	D570	0.9
Melt Flow Rate (275°C, 2.16kg)	g/10min	D1238	8
MECHANICAL			
Tensile Strength	kg _f /cm ²	D638	1,600
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	2,100
Flexural Modulus	kg _f /cm ²	D790	66,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	7
Rockwell Hardness	R scale	D785	-
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	246
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	-
OTHERS			
UL-94 Flammability (0.75mm thickness)	-	(UL 94)	HB
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	0.6~0.9

※ 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 TRAMID 923G25 GRADE

- General processing conditions for TRAMID 923G25 are shown below.
- Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	70 ~ 80
Drying Time	hr	5 ~ 7
Moisture Content, Max	%	0.2
Melt Temperature	°C	270 ~ 290
Nozzle Temperature	°C	270 ~ 300
Front Temperature	°C	270 ~ 300
Middle Temperature	°C	260 ~ 290
Rear Temperature	°C	220 ~ 260
Mold Temperature	°C	20 ~ 70
Back Pressure	MPa	0.1 ~ 0.5
Screw Speed	rpm	30 ~ 70
Vent Depth	mm	0.02 ~ 0.08