

TECHNICAL DATASHEET

TRIECO[®] 3D30

Eco-PC Resin

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	11
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	600
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	20,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	70
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	130
ELECTRICAL			
OTHERS			
UL-94 Flammability (0.7mm thickness)	-	(UL 94)	HB
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

TRIECO® 3D30 GRADE

Eco-PC Resin

- General processing conditions for TRIECO3D30 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	℃	280~310
Nozzle Temperature	℃	270~300
Front Temperature	℃	270~300
Middle Temperature	℃	270~300
Rear Temperature	℃	250~280
Mold Temperature	℃	50~80
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

Global Network

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