

## TECHNICAL DATASHEET

**TRILEN<sup>®</sup> 9500G40**

PP

| PROPERTY                                  | UNIT                             | ASTM METHOD | TYPICAL DATA |
|-------------------------------------------|----------------------------------|-------------|--------------|
| <b>PHYSICAL</b>                           |                                  |             |              |
| Specific Gravity                          | -                                | D792        | 1.22         |
| Melt Flow Rate (230℃, 2.16kg)             | g/10min                          | D1238       | 23           |
| <b>MECHANICAL</b>                         |                                  |             |              |
| Tensile Strength at yield                 | kg <sub>f</sub> /cm <sup>2</sup> | D638        | 850          |
| Tensile Elongation at break               | %                                | D638        | 3.5          |
| Flexural Strength at yield                | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 1,300        |
| Flexural Modulus                          | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 70,000       |
| Izod Impact Strength, notched, 23℃ (1/8") | kg <sub>f</sub> ·cm/cm           | D256        | 10           |
| <b>THERMAL</b>                            |                                  |             |              |
| HDT, 18.6 kgf/cm <sup>2</sup>             | ℃                                | D648        | 153          |
| <b>ELECTRICAL</b>                         |                                  |             |              |
| <b>OTHERS</b>                             |                                  |             |              |
| UL-94 Flammability                        | -                                | (UL 94)     | HB           |

※ 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

# TRILEN<sup>®</sup> 9500G40 GRADE

PP

- General processing conditions for TRILEN9500G40 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

| SPECIFICATION         | UNIT | CONDITIONS |
|-----------------------|------|------------|
| Drying Temperature    | ℃    | 80-90      |
| Drying Time           | hr   | 3-4        |
| Moisture Content, Max | %    | 0.02       |
| Melt Temperature      | ℃    | 220-240    |
| Nozzle Temperature    | ℃    | 215-235    |
| Front Temperature     | ℃    | 220-240    |
| Middle Temperature    | ℃    | 220-240    |
| Rear Temperature      | ℃    | 225-245    |
| Mold Temperature      | ℃    | 50-80      |
| Back Pressure         | MPa  | <70        |
| Screw Speed           | rpm  | <60        |
| Injection Pressure    | MPa  | <70        |
| Injection Speed       | %    | <50        |
| Hold Pressure         | MPa  | <50        |
| Injection Cushion     | mm   | 3-6        |

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