

TECHNICAL DATASHEET

TRILOY® 210GNH10

PC/ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.31
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (250°C, 5kg)	g/10min	D1238	15
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	700
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	1,100
Flexural Modulus	kg _f /cm ²	D790	38,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	7
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	92
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.4mm thickness)	-	(UL 94)	V-0
Mold Shrinkage (3mm thickness)	%	D955	0.3-0.5

※ 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

TRILOY® 210GNH10 GRADE

PC/ABS

- General processing conditions for TRILOY210GNH10 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	3-5
Moisture Content, Max	%	0.02
Melt Temperature	℃	250-280
Nozzle Temperature	℃	250-280
Front Temperature	℃	250-280
Middle Temperature	℃	230-275
Rear Temperature	℃	220-250
Mold Temperature	℃	80-100
Back Pressure	MPa	0.4-0.6
Screw Speed	rpm	50-60
Vent Depth	mm	0.02-0.08
Injection Pressure	MPa	50-80
Injection Speed	%	30-60
Hold Pressure	MPa	35-60
Injection Cushion	mm	3-6

Global Network

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