

TECHNICAL DATASHEET

TRILOY® 210NH

PC/ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.17
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	17
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	620
Tensile Elongation at break	%	D638	100
Flexural Strength at yield	kg _f /cm ²	D790	900
Flexural Modulus	kg _f /cm ²	D790	24,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	60
Rockwell Hardness	R scale	D785	116
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	98
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	8.3 x 10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	9E+16
Dielectric Strength	kV/mm	D149	30
Dielectric Constant	-	D150	3
Dissipation Factor	-	D150	0.009
ARC Resistance	sec	D495	120
OTHERS			
UL-94 Flammability (1.7mm thickness)	-	(UL 94)	V-0
Mold Shrinkage (3mm thickness)	%	D955	0.4~0.6

※ 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® 210NH GRADE

PC/ABS

- General processing conditions for TRILOY210NH 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	℃	240-270
Nozzle Temperature	℃	240-270
Front Temperature	℃	240-270
Middle Temperature	℃	220-265
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	%	20-50
Hold Pressure	MPa	35-60
Injection Cushion	mm	3-6

Global Network

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