

TECHNICAL DATASHEET

TRILOY® 210NHFL

PC/ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.18
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	15
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	600
Tensile Elongation at break	%	D638	70
Flexural Strength at yield	kg _f /cm ²	D790	900
Flexural Modulus	kg _f /cm ²	D790	26,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	40
Rockwell Hardness	R scale	D785	116
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	87
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 (1.0mm thickness)	-	(UL 94)	V-0
UL-94 Flammability (2.5mm thickness)			V-0, 5VB
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

TRILOY® 210NHFL GRADE

PC/ABS

- General processing conditions for TRILOY210NHFL are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	80
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	240~260
Nozzle Temperature	℃	240~260
Front Temperature	℃	235~255
Middle Temperature	℃	235~255
Rear Temperature	℃	230~250
Mold Temperature	℃	60~80
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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