

TECHNICAL DATASHEET

TRILOY® 215HF

PC/ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.14
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (250°C, 5kg)	g/10min	D1238	12
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	460
Tensile Elongation at break	%	D638	50
Flexural Strength at yield	kg _f /cm ²	D790	700
Flexural Modulus	kg _f /cm ²	D790	24,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	55
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	103
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	7.3 x 10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	5E+16
Dielectric Strength	kV/mm	D149	25
Dielectric Constant	-	D150	3
Dissipation Factor	-	D150	0.009
ARC Resistance	sec	D495	123
OTHERS			
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® 215HF GRADE

PC/ABS

- General processing conditions for TRILOY215HF are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	90~100
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	260~280
Nozzle Temperature	℃	260~280
Front Temperature	℃	260~280
Middle Temperature	℃	250~270
Rear Temperature	℃	250~270
Mold Temperature	℃	40~60
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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