

TECHNICAL DATASHEET

TRILOY® 270GNH15

Polycarbonate/ABS Resin

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.28
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	27
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	850
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg _f /cm ²	D790	1,100
Flexural Modulus	kg _f /cm ²	D790	53,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	6
Rockwell Hardness	R scale	D785	121
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	96
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	86, 102, 129
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.4mm thickness)	-	(UL 94)	V-0
UL-94 Flammability (1.5mm thickness)			V-0
UL-94 Flammability (2.0mm thickness)			V-0
UL-94 Flammability (3.0mm thickness)			V-0
Mold Shrinkage (3mm thickness)	%	D955	0.2~0.4

※ 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® 270GNH15 GRADE

Polycarbonate/ABS Resin

- General processing conditions for TRILOY270GNH15 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	85
Drying Time	hr	3 ~ 5
Moisture Content, Max	%	0.02
Melt Temperature	℃	250 ~ 270
Nozzle Temperature	℃	250 ~ 290
Front Temperature	℃	250 ~ 280
Middle Temperature	℃	250 ~ 280
Rear Temperature	℃	250 ~ 270
Mold Temperature	℃	40 ~ 90
Back Pressure	MPa	< 70
Screw Speed	rpm	< 60
Injection Pressure	MPa	< 70
Injection Speed	%	< 50
Hold Pressure	MPa	< 50
Injection Cushion	mm	3 ~ 6

Global Network

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