

TECHNICAL DATASHEET

TRILOY® 410

PC/PET

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.23
Water Absorption (24 hours at 23°C)	%	D570	0.15
Melt Flow Rate (250°C, 3.8kg)	g/10min	D1238	17
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	580
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	21,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	70
Rockwell Hardness	R scale	D785	118
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	120
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	0.7~1.2

※ 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® 410 GRADE

PC/PET

- General processing conditions for TRILOY410 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	100~110
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	260~280
Nozzle Temperature	℃	255~275
Front Temperature	℃	260~280
Middle Temperature	℃	255~275
Rear Temperature	℃	250~270
Mold Temperature	℃	60~90

Global Network

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