

TECHNICAL DATASHEET

TRILOY® 640G20

ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.16
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (220°C, 10kg)	g/10min	D1238	8
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	650
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	45,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	5
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	99
ELECTRICAL			
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® 640G20 GRADE

ABS

- General processing conditions for TRILOY640G20 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	90
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	220~240
Nozzle Temperature	℃	220~240
Front Temperature	℃	210~230
Middle Temperature	℃	210~230
Rear Temperature	℃	190~200
Mold Temperature	℃	50~80
Back Pressure	MPa	0.3~0.5
Screw Speed	rpm	40
Vent Depth	mm	0.02~0.08

Global Network

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