

TECHNICAL DATASHEET

TRILOY[®] DM280R

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.32
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	50
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	500
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	38,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	4.5
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	84
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.0mm)	-	(UL 94)	V-1
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® DM280R GRADE

- General processing conditions for TRILOYDM280R are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	70~80
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~280
Nozzle Temperature	℃	240~270
Front Temperature	℃	245~265
Middle Temperature	℃	245~265
Rear Temperature	℃	235~265
Mold Temperature	℃	60~90
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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