

TECHNICAL DATASHEET

TRILOY® TP270W

PC/ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.34
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	40
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	500
Tensile Elongation at break	%	D638	4
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	42,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	3
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	82
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.4mm thickness)	-	(UL 94)	V-0

※ 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® TP270W GRADE

PC/ABS

- General processing conditions for TRILOYTP270W 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	4~6
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~270
Nozzle Temperature	℃	250~260
Front Temperature	℃	250~260
Middle Temperature	℃	245~265
Rear Temperature	℃	230~250
Mold Temperature	℃	40~60
Back Pressure	MPa	0.4~0.6
Screw Speed	rpm	50~60
Vent Depth	mm	0.02~0.08
Injection Pressure	MPa	50~80
Injection Speed	%	20~50
Hold Pressure	MPa	35~60
Injection Cushion	mm	3~6

Global Network

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