

TECHNICAL DATASHEET

TRIEX[®] 3022R

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.20
Water Absorption (24 hours at 23°C)	%	D570	0.15
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	15
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	630
Tensile Elongation at break	%	D638	180
Flexural Strength at yield	kg _f /cm ²	D790	900
Flexural Modulus	kg _f /cm ²	D790	22,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	80
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	132
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	5~7 x 10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	4E+16
Dielectric Strength	kV/mm	D149	30
Dielectric Constant	-	D150	2.85
Dissipation Factor	-	D150	0.0092
ARC Resistance	sec	D495	120
OTHERS			
UL-94 Flammability (0.5mm thickness)	-	(UL 94)	V-2
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

TRIREX[®] 3022R GRADE

PC

- General processing conditions for TRIREX3022R are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	290~310
Nozzle Temperature	℃	280~315
Front Temperature	℃	290~315
Middle Temperature	℃	270~300
Rear Temperature	℃	260~280
Mold Temperature	℃	65~105
Back Pressure	MPa	0.3~0.7
Screw Speed	rpm	40~70
Vent Depth	mm	0.02~0.08

Global Network

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