

## TECHNICAL DATASHEET

**TRIEX<sup>®</sup> 3022U**

PC

| PROPERTY                                   | UNIT                | ASTM METHOD | TYPICAL DATA           |
|--------------------------------------------|---------------------|-------------|------------------------|
| <b>PHYSICAL</b>                            |                     |             |                        |
| 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       | 30                     |
| <b>MECHANICAL</b>                          |                     |             |                        |
| Tensile Strength at yield                  | kgf/cm <sup>2</sup> | D638        | 650                    |
| Tensile Elongation at break                | %                   | D638        | 180                    |
| Flexural Strength at yield                 | kgf/cm <sup>2</sup> | D790        | 850                    |
| Flexural Modulus                           | kgf/cm <sup>2</sup> | D790        | 23,000                 |
| Izod Impact Strength, notched, 23°C (1/8") | kgf·cm/cm           | D256        | 75                     |
| Rockwell Hardness                          | R scale             | D785        | 120                    |
| <b>THERMAL</b>                             |                     |             |                        |
| HDT, 18.6 kgf/cm <sup>2</sup>              | °C                  | D648        | 132                    |
| Coefficient of Linear Thermal Expansion    | mm/mm/°C            | D696        | 5~7 x 10 <sup>-5</sup> |
| <b>ELECTRICAL</b>                          |                     |             |                        |
| 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                    |
| <b>OTHERS</b>                              |                     |             |                        |
| 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<sup>®</sup> 3022U GRADE

PC

- General processing conditions for TRIREX3022U 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  | 0.4~0.6    |
| Screw Speed           | rpm  | 50~70      |
| Vent Depth            | mm   | 0.02~0.08  |
| Injection Pressure    | MPa  | 70~140     |
| Injection Speed       | %    | 50~80      |
| Hold Pressure         | MPa  | 35~60      |
| Injection Cushion     | mm   | 3~6        |

## Global Network

### HEAD OFFICE

Samyang Corporation  
31, Jong-ro 33-gil, Jongno-gu, Seoul, Korea  
T. +82-2-740-7747

### Chemical Research Center

730, Daedeok-daero, Yuseong-gu, Daejeon, Korea  
T. +82-42-865-8114

### JEONJU ENGINEERING PLASTIC PLANT

147, Palbok-ro, Deokjin-gu, Jeonju, Korea  
T. +82-63-210-6664

### SAMYANG ENGINEERING PLASTICS (SHANGHAI) CO., LTD.

No.131, Shuangying Road, Qingpu Industrial Area,  
Qingpu County, Shanghai, China  
T. +86-21-6922-2270

### SAMYANG ENGINEERING PLASTICS (HUNGARY) CO., LTD.

H5100, Jaszbereny, Necso, Telep 1, Hungary  
T. +36-21-311-1263

### SAMYANG ENGINEERING PLASTICS (VIETNAM) LLC

1 Song Hanh Road, Nhon Trach 6 Industrial Zone, Long Tho  
Commune, Nhon Trach District, Dong Nai Province, Vietnam  
T. +84-0251-3686-707