

TECHNICAL DATASHEET

TRIEX[®] 3025R

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	12
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	620
Tensile Elongation at break	%	D638	100
Flexural Strength at yield	kg _f /cm ²	D790	650
Flexural Modulus	kg _f /cm ²	D790	21,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	75
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/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[®] 3025R GRADE

PC

- General processing conditions for TRIREX3025R 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	℃	280~300
Nozzle Temperature	℃	280~300
Front Temperature	℃	270~290
Middle Temperature	℃	260~280
Rear Temperature	℃	260~280
Mold Temperature	℃	60~80
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

JEONJU ENGINEERING PLASTIC PLANT

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

SAMYANG ENGINEERING PLASTICS (HUNGARY) CO., LTD.

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

Chemical Research Center

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

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 (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