

## TECHNICAL DATASHEET

**TRIEX<sup>®</sup> 3026B-L**

PC

| PROPERTY                                  | UNIT                             | ASTM METHOD | TYPICAL DATA |
|-------------------------------------------|----------------------------------|-------------|--------------|
| <b>PHYSICAL</b>                           |                                  |             |              |
| Specific Gravity                          | -                                | D792        | 1.20         |
| Water Absorption (24 hours at 23℃)        | %                                | D570        | 0.15         |
| Melt Flow Rate (300℃, 1.2kg)              | g/10min                          | D1238       | 2.5          |
| <b>MECHANICAL</b>                         |                                  |             |              |
| Tensile Strength at yield                 | kg <sub>f</sub> /cm <sup>2</sup> | D638        | 650          |
| Tensile Elongation at break               | %                                | D638        | 120          |
| Flexural Strength at yield                | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 900          |
| Flexural Modulus                          | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 22,000       |
| Izod Impact Strength, notched, 23℃ (1/8") | kg <sub>f</sub> ·cm/cm           | D256        | 80           |
| Rockwell Hardness                         | R scale                          | D785        | 120          |
| <b>THERMAL</b>                            |                                  |             |              |
| HDT, 18.6 kgf/cm <sup>2</sup>             | ℃                                | D648        | 130          |
| <b>ELECTRICAL</b>                         |                                  |             |              |
| <b>OTHERS</b>                             |                                  |             |              |
| 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> 3026B-L GRADE

PC

- General processing conditions for TRIREX3026B-L 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      | ℃    | 290~320    |
| Nozzle Temperature    | ℃    | 280~300    |
| Front Temperature     | ℃    | 280~300    |
| Middle Temperature    | ℃    | 270~290    |
| Rear Temperature      | ℃    | 265~285    |
| Mold Temperature      | ℃    | 80~100     |
| 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        |

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