

TECHNICAL DATASHEET

TRIEX[®] 3500G20

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.34
Water Absorption (24 hours at 23°C)	%	D570	0.12
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	7
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,000
Tensile Elongation at break	%	D638	8
Flexural Strength at yield	kg _f /cm ²	D790	1,600
Flexural Modulus	kg _f /cm ²	D790	50,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	12
Rockwell Hardness	R scale	D785	122
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	147
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	2.3 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 (1.5mm thickness)	-	(UL 94)	V-0
Mold Shrinkage (3mm thickness)	%	D955	0.1-0.3

※ 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[®] 3500G20 GRADE

PC

- General processing conditions for TRIREX3500G20 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	℃	310~330
Nozzle Temperature	℃	300~320
Front Temperature	℃	300~320
Middle Temperature	℃	290~310
Rear Temperature	℃	280~300
Mold Temperature	℃	80~110
Back Pressure	MPa	0.3~0.7
Screw Speed	rpm	50~70
Vent Depth	mm	0.02~0.08

Global Network

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