

TECHNICAL DATASHEET

TRIEX[®] HB3025G20

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	8
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	850
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg _f /cm ²	D790	1,300
Flexural Modulus	kg _f /cm ²	D790	46,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	9
Rockwell Hardness	R scale	D785	122
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	143
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	31
Dielectric Constant	-	D150	3.05
Dissipation Factor	-	D150	0.0097
ARC Resistance	sec	D495	120
OTHERS			
UL-94 Flammability (0.75mm thickness)	-	(UL 94)	HB
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[®] HB3025G20 GRADE

PC

- General processing conditions for TRIREXHB3025G20 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	℃	280~310
Nozzle Temperature	℃	280~310
Front Temperature	℃	280~310
Middle Temperature	℃	270~300
Rear Temperature	℃	260~290
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

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