

TECHNICAL DATASHEET

TRIEX[®] HM3022G10

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.25
Water Absorption (24 hours at 23°C)	%	D570	0.12
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	6
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	500
Tensile Elongation at break	%	D638	10
Flexural Strength at yield	kg _f /cm ²	D790	850
Flexural Modulus	kg _f /cm ²	D790	30,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	26
Rockwell Hardness	R scale	D785	122
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	138
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	3.2 x 10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	4E+16
Dielectric Strength	kV/mm	D149	19
Dielectric Constant	-	D150	3.11
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	0.2-0.4

※ 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[®] HM3022G10 GRADE

PC

- General processing conditions for TRIREX[®]HM3022G10 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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