

TECHNICAL DATASHEET

TRIEX[®] M3020PN

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.18
Water Absorption (24 hours at 23°C)	%	D570	0.15
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	30
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	620
Tensile Elongation at break	%	D638	90
Flexural Strength at yield	kg _f /cm ²	D790	900
Flexural Modulus	kg _f /cm ²	D790	23,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	65
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	100
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	5.6 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	90
OTHERS			
UL-94 Flammability (0.4mm thickness)	-	(UL 94)	V-2
UL-94 Flammability (0.75mm thickness)			V-0
UL-94 Flammability (2.0mm thickness)			V-0, 5VB
UL-94 Flammability (3.0mm thickness)			V-0, 5VA
Mold Shrinkage	%		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[®] M3020PN GRADE

PC

- General processing conditions for TRIREXM3020PN are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	70~80
Drying Time	hr	3~5
Moisture Content, Max	%	0.02
Melt Temperature	℃	270~290
Nozzle Temperature	℃	270~290
Front Temperature	℃	260~280
Middle Temperature	℃	260~280
Rear Temperature	℃	250~270
Mold Temperature	℃	60~80
Back Pressure	MPa	0.4~0.6
Screw Speed	rpm	50~70
Vent Depth	mm	0.02~0.08

Global Network

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