

TECHNICAL DATASHEET

TRIRES[®] M3022H

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.20
Water Absorption (24 hours at 23°C)	%	D570	0.15
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	11
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	600
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	20,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	70
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	126
ELECTRICAL			
OTHERS			
UL-94 Flammability (0.7~0.77mm thickness)	-	(UL 94)	HB
UL-94 Flammability (0.8~0.88mm thickness)			V-2
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[®] M3022H GRADE

PC

- General processing conditions for TRIREXM3022H 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	℃	290~310
Front Temperature	℃	290~310
Middle Temperature	℃	280~300
Rear Temperature	℃	270~290
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

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