

TECHNICAL DATASHEET

TRIEX[®] M3025H

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	14
MECHANICAL			
Tensile Strength at yield	kgf/cm ²	D638	600
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kgf/cm ²	D790	850
Flexural Modulus	kgf/cm ²	D790	20,000
Izod Impact Strength, notched, 23°C (1/8")	kgf·cm/cm	D256	70
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	130
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 (0.7~0.77mm 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[®] M3025H GRADE

PC

- General processing conditions for TRIREXM3025H are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	110~120
Drying Time	hr	3~5
Moisture Content, Max	%	0.02
Melt Temperature	℃	280~300
Nozzle Temperature	℃	280~310
Front Temperature	℃	280~300
Middle Temperature	℃	270~290
Rear Temperature	℃	260~280
Mold Temperature	℃	60~110
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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