

TECHNICAL DATASHEET

TRIRES[®] NH3022PN3

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.20
Water Absorption (24 hours at 23°C)	%	D570	0.13
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	27
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	700
Tensile Elongation at break	%	D638	160
Flexural Strength at yield	kg _f /cm ²	D790	1,000
Flexural Modulus	kg _f /cm ²	D790	25,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	6
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	108
ELECTRICAL			
OTHERS			
UL-94 Flammability (2.0mm thickness)	-	(UL 94)	V-0
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[®] NH3022PN3 GRADE

PC

- General processing conditions for TRIREXNH3022PN3 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	100
Drying Time	hr	3-5
Moisture Content, Max	%	0.02
Melt Temperature	℃	260~280
Nozzle Temperature	℃	260~280
Front Temperature	℃	260~280
Middle Temperature	℃	255~275
Rear Temperature	℃	250~270
Mold Temperature	℃	50~80
Back Pressure	MPa	0.3~0.7
Screw Speed	rpm	40~70
Vent Depth	mm	0.025~0.076

Global Network

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