

## TECHNICAL DATASHEET

**TRIRES<sup>®</sup> SM3-3010H**

PC

| PROPERTY                                   | UNIT                             | ASTM METHOD | TYPICAL DATA |
|--------------------------------------------|----------------------------------|-------------|--------------|
| <b>PHYSICAL</b>                            |                                  |             |              |
| Specific Gravity                           | -                                | D792        | 1.20         |
| Water Absorption (24 hours at 23°C)        | %                                | D570        | 0.16         |
| Melt Flow Rate (300°C, 1.2kg)              | g/10min                          | D1238       | 10           |
| <b>MECHANICAL</b>                          |                                  |             |              |
| Tensile Strength at yield                  | kg <sub>f</sub> /cm <sup>2</sup> | D638        | 580          |
| Tensile Elongation at break                | %                                | D638        | 100          |
| Flexural Strength at yield                 | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 780          |
| Flexural Modulus                           | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 19,500       |
| Izod Impact Strength, notched, 23°C (1/8") | kg <sub>f</sub> ·cm/cm           | D256        | 70           |
| <b>THERMAL</b>                             |                                  |             |              |
| HDT, 18.6 kg <sub>f</sub> /cm <sup>2</sup> | °C                               | D648        | 128          |
| <b>ELECTRICAL</b>                          |                                  |             |              |
| <b>OTHERS</b>                              |                                  |             |              |
| UL-94 Flammability (0.8~0.88mm thickness)  | -                                | (UL 94)     | V-2          |
| 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<sup>®</sup> SM3-3010H GRADE

PC

- General processing conditions for TRIREXSM3-3010H 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   | 3-5        |
| Melt Temperature   | ℃    | 290-320    |
| Nozzle Temperature | ℃    | 280-330    |
| Front Temperature  | ℃    | 280-330    |
| Middle Temperature | ℃    | 275-310    |
| Rear Temperature   | ℃    | 260-290    |
| Mold Temperature   | ℃    | 65-105     |
| Back Pressure      | MPa  | 0.3-0.7    |
| Screw Speed        | rpm  | 40-70      |
| Vent Depth         | mm   | 0.02-0.08  |

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