

TECHNICAL DATASHEET

TRIEX[®] SO4-3025UPNV

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	8
MECHANICAL			
Tensile Strength at yield	kgf/cm ²	D638	580
Tensile Elongation at break	%	D638	130
Flexural Strength at yield	kgf/cm ²	D790	780
Flexural Modulus	kgf/cm ²	D790	21,000
Izod Impact Strength, notched, 23°C (1/8")	kgf·cm/cm	D256	80
Rockwell Hardness	R scale	D785	128
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	125
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	5~7 x 10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	1.0 x 10 ¹⁵
Dielectric Strength	kV/mm	D149	30
Dielectric Constant	-	D150	2.85
Dissipation Factor	-	D150	0.0092
ARC Resistance	sec	D495	120
OTHERS			
UL-94 Flammability (0.75mm thickness)	-	(UL 94)	HB
UL-94 Flammability (1.5mm thickness)			V-0
UL-94 Flammability (2.5mm thickness)			V-0, 5VB
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[®] SO4-3025UPNV GRADE

PC

- General processing conditions for TRIREXSO4-3025UPNV are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	100~110
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	280~300
Nozzle Temperature	℃	280~300
Front Temperature	℃	270~290
Middle Temperature	℃	260~280
Rear Temperature	℃	260~280
Mold Temperature	℃	60~80
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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