

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	3
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	700
Tensile Elongation at break	%	D638	130
Flexural Strength at yield	kg _f /cm ²	D790	900
Flexural Modulus	kg _f /cm ²	D790	20,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	85
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	136
HDT, 4.6 kg _f /cm ²	°C		147
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	5~7 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	120
OTHERS			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	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.

TRIREX[®] 3030IR GRADE

- General processing conditions for TRIREX3030IR are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	120
Drying Time	hr	3-4
Moisture Content, Max	%	0.02
Melt Temperature	°C	290-320
Nozzle Temperature	°C	290-310
Front Temperature	°C	290-310
Middle Temperature	°C	280-300
Rear Temperature	°C	270-290
Mold Temperature	°C	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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