

TECHNICAL DATASHEET

# TRIREX<sup>®</sup> HV3022G10

PC

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
<b>PHYSICAL</b>			
Specific Gravity	-	D792	1.25
Water Absorption (24 hours at 23°C)	%	D570	0.12
Melt Flow Rate (300°C, 1.2kg)	g/10min	D1238	12
<b>MECHANICAL</b>			
Tensile Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D638	650
Tensile Elongation at break	%	D638	5
Flexural Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D790	1,000
Flexural Modulus	kg <sub>f</sub> /cm <sup>2</sup>	D790	30,000
Izod Impact Strength, notched, 23°C (1/8")	kg <sub>f</sub> ·cm/cm	D256	21
Rockwell Hardness	R scale	D785	122
<b>THERMAL</b>			
HDT, 18.6 kgf/cm <sup>2</sup>	°C	D648	136
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	3.2 x 10 <sup>-5</sup>
<b>ELECTRICAL</b>			
Volume Resistivity	Ω·cm	D257	4E+16
Dielectric Strength	kV/mm	D149	19
Dielectric Constant	-	D150	3.11
Dissipation Factor	-	D150	0.0097
ARC Resistance	sec	D495	120
<b>OTHERS</b>			
UL-94 Flammability (0.75mm thickness)	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	0.2-0.4

※ 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> HV3022G10 GRADE

PC

- General processing conditions for TRIREXHV3022G10 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	310-330
Nozzle Temperature	°C	300-320
Front Temperature	°C	300-320
Middle Temperature	°C	290-310
Rear Temperature	°C	280-300
Mold Temperature	°C	80-110
Back Pressure	MPa	0.3-0.7
Screw Speed	rpm	50-70
Vent Depth	mm	0.02-0.08

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