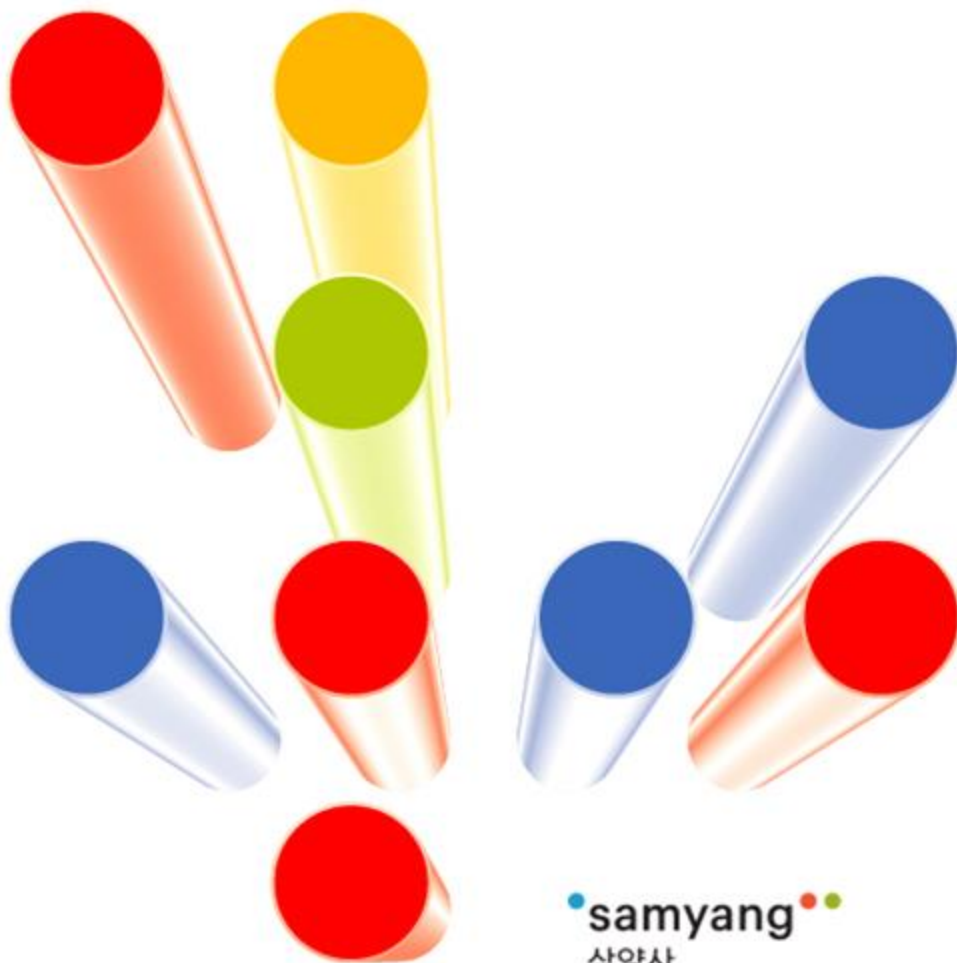


# TRIEX<sup>®</sup> 3022U

## *Polycarbonate Resin*



# TYPICAL DATA OF TRIREX 3022U GRADE

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
<b>PHYSICAL</b>			
Specific Gravity	-	D792	1.2
Water Absorption (24 hours at 23 °C)	%	D570	0.15
Melt Flow Rate (300°C, 1.2 kg)	g/10min	D1238	11
<b>MECHANICAL</b>			
Tensile Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D638	690
Tensile Elongation at break	%	D638	230
Flexural Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D790	840
Flexural Modulus	kg <sub>f</sub> /cm <sup>2</sup>	D790	24,000
Izod Impact Strength, notched, 23 °C (1/8")	kg <sub>f</sub> ·cm/cm	D256	87.3
Rockwell Hardness	R scale	D785	120
<b>THERMAL</b>			
HDT, 18.6 kg <sub>f</sub> /cm <sup>2</sup>	°C	D648	133
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	5.6x10 <sup>-5</sup>
<b>ELECTRICAL</b>			
Volume Resistivity	Ω·cm	D257	4x10 <sup>16</sup>
Dielectric Strength	kV/mm	D149	30
Dielectric Constant, 10 <sup>6</sup> HZ	10 <sup>6</sup> HZ	D150	2.85
Dissipation Factor	10 <sup>6</sup> HZ	D150	0.0092
ARC Resistance	sec	D495	120
<b>OTHERS</b>			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	V-2
Mold Shrinkage (3.2mm 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 FOR TRIREX 3022U GRADE

- General processing conditions for TRIREX 3022U 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 ~ 310
Nozzle Temperature	°C	280 ~ 315
Front Temperature	°C	290 ~ 315
Middle Temperature	°C	275 ~ 300
Rear Temperature	°C	260 ~ 280
Mold Temperature	°C	65 ~ 105
Back Pressure	%	350 ~ 700
Screw Speed	%	50 ~ 70

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