Dayson Polymers, LLC

TRILOY® 200

Acrylonitrile Butadiene Styrene & PC Alloy

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Density – Specific Gravity	sp gr 23/23°C	1.08	ASTM 792
Melt Flow Rate	250°C/5.0 kg	11 g/10min	ASTM D1238
Mold Shrink, Linear-Flow (0.118in)	in/in	0.0050 to 0.0070	ASTM 955
Water Absorption @ 24 hours	%	.20	ASTM D570
Mechanical			
Tensile Strength		7,820 psi	ASTM D638
Tensile Elongation @ Break	%	100	ASTM D638
Flexural Modulus		312,914 psi	ASTM D790
Flexural Strength		11,100 psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125in)	ft-lb/in	13.78	ASTM D256
Hardness			
Rockwell Hardness	R-Scale	115	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed		216 °F	ASTM D648
CLTE, Flow	in/in/°F	4.1E-005	ASTM D696
Electrical			
Volume Resistivity		5.0E+016 ohm-cm	ASTM D257
Dielectric Strength	V/mil	635	ASTM D149
Dielectric Constant	1000000 Hz	3.000	ASTM D150
Dissipation Factor	1000000 Hz	0.0090	ASTM D150
Arc Resistance	sec	123	ASTM D495
Ignition Characteristics			
Flame Rating – UL (0.0625in)		HB	UL94

PROCESSING INFORMATION

INJECTION MOLDING PARAMETERS	NOMINAL VALUES (ENGLISH)
DRYING TEMPERATURE	248 °F
DRYING TIME	3.0 HR
REAR TEMPERATURE	392 to 428 °F
MIDDLE TEMPERATURE	428 to 446 °F
FRONT TEMPERATURE	446 to 464 °F
NOZZLE TEMPERATURE	464 to 482 °F
MOLD TEMPERATURE	140 to 176 °F
INJECTION PRESSURE	5690 to 11400 psi
SCREW SPEED	40 to 60 rpm

AUTOMOTIVE EXTERIOR PARTS, AUTOMOTIVE INTERIOR PARTS, STRUCTURAL PARTS

Remark: The values presented on the above are typical laboratory averages. All data generated is based on natural material.