

Dayson Polymers, LLC

TRIEX® POLYCARBONATE 3027 High Viscosity

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Density – Specific Gravity	sp gr 23/23°C	1.20	ASTM 792
Melt Flow Rate	(230°C/3.8 kg – I)	23 g/10min	ASTM D1238
Mold Shrink, Linear-Flow (0.118in)	in/in	0.0050 to 0.0070	ASTM 955
Water Absorption @ 24 hours	%	.15	ASTM D570
Mechanical			
Tensile Strength		10,200 psi	ASTM D638
Tensile Elongation @ Break	%	120	ASTM D638
Flexural Modulus		284,467 psi	ASTM D790
Flexural Strength		12,800 psi	ASTM D790
Impact			
Notched Izod Impact (0.125in)	ft-lb/in	17.45	ASTM D256
Hardness			
Rockwell Hardness	R-Scale	120	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed		277 °F	ASTM D648
DTUL @ 66 psi - Unannealed		297 °F	ASTM D648
CLTE, Flow	in/in/°F	3.1E-005	ASTM D696
Electrical			
Volume Resistivity		4.0E+016 ohm-cm	ASTM D257
Dielectric Strength	V/mil	762	ASTM D149
Dielectric Constant	1000000 Hz	2.850	ASTM D150
Dissipation Factor	1000000 Hz	0.0092	ASTM D150
Ignition Characteristics			
Flame Rating – UL (0.0625in)		V-2	UL94

PROCESSING INFORMATION

INJECTION MOLDING PARAMETERS	NOMINAL VALUES (ENGLISH)
DRYING TEMPERATURE	248 °F
DRYING TIME	6.0 HR
REAR TEMPERATURE	464 to 536 °F
MIDDLE TEMPERATURE	518 to 590 °F
FRONT TEMPERATURE	518 to 590 °F
NOZZLE TEMPERATURE	518 to 572 °F
PROCESSING (MELT) TEMP	518 to 590 °F
MOLD TEMPERATURE	158 to 230 °F
INJECTION PRESSURE	11400 to 19900 psi

**HIGH VISCOSITY
CAMERA, LIGHT COVER**

*HF: High Flow, IR: Ice Clear and Releasing Agent, U: UV-Stabilized,
*02: Blue Tinted Grade

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Remark: The values presented on the above are typical laboratory averages. All data generated is based on natural material. To the best of our knowledge the information contained in this publication is accurate, however, we do not assume any liability whatsoever for the accuracy or completeness of such information. Since we have no control over the use to which others may put our product, we cannot guarantee that results will be the same as those described in this publication will be obtained. The buyer assumes sole responsibility for results obtained in reliance upon this publication. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves as to such suitability and they can meet all applicable safety and health standards.