

Dayson Polymers, LLC

TRIREX® POLYCARBONATE 3500G20

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Density – Specific Gravity	sp gr 23/23°C	1.34	ASTM 792
Mold Shrink, Linear-Flow (0.118in)	in/in	0.0030 to 0.0050	ASTM 955
Water Absorption @ 24 hours	%	.12	ASTM D570
Mechanical			
Tensile Strength		15,600 psi	ASTM D638
Tensile Elongation @ Yld	%	4.0	ASTM D638
Tensile Elongation @ Break	%	9.0	ASTM D638
Flexural Modulus		711,167 psi	ASTM D790
Flexural Strength		24,200 psi	ASTM D790
Impact			
Notched Izod Impact (0.500in)	ft-lb/in	2.75	ASTM D256
Notched Izod Impact (0.125in)	ft-lb/in	2.94	ASTM D256
Hardness			
Rockwell Hardness	R-Scale	122	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed		297 °F	ASTM D648
DTUL @ 66 psi - Unannealed		304 °F	ASTM D648
CLTE, Flow	in/in/°F	1.3E-005	ASTM D696
Electrical			
Volume Resistivity		4.0E+016 ohm-cm	ASTM D257
Dielectric Strength	V/mil	787	ASTM D149
Dielectric Constant	1000000 Hz	3.110	ASTM D150
Dissipation Factor	1000000 Hz	0.0097	ASTM D150
Arc Resistance	sec	120	ASTM D495
Ignition Characteristics			
Flame Rating – UL (0.0625in)		V-0	UL94
Flame Rating – UL (0.125in)		V-0	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

20% G/F REINFORCED (*HF: High Flow, IR: Ice Clear and Releasing Agent, U: UV-Stabilized, *-02: Blue Tinted Grade)

ELECTRICAL/ELECTRONIC APPLICATIONS, AUTOMOTIVE APPLICATIONS, PACKAGING, FOOD

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

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