

Product Information

TRIECO 4D40G40 BK (OCEAN)

PA6/Eco plastic

TRIECO 4D40G40 BK (OCEAN)
contains a minimum of 28% ocean plastic.



TYPICAL DATA OF TRIECO 4D40G40 BK (OCEAN)

PROPERTY	UNIT	METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	ISO 1183	1.48
MECHANICAL			
Tensile Strength at yield	MPa	ISO 527	192
Tensile Elongation at break	%	ISO 527	>2.5
Tensile Modulus	MPa	ISO 527	>11800
Flexural Strength at yield	MPa	ISO 178	220
Flexural Modulus	MPa	ISO 178	>12000
Izod Impact Strength, notched, 23°C (1/8")	kJ/m ²	ISO 180	>11.0
Charpy Impact, notched, 23°C	kJ/m ²	ISO 179-1	>11.0
Charpy Impact, notched, -40°C	kJ/m ²	ISO 179-1	>9.0
THERMAL			
HDT, 1.80MPa	°C	ISO 75	205
OTHERS			
Mold Shrinkage	%	ASTM D955	<0.2
Long term Heat Stability	Retention%	-	
140°C 1000H, tensile strength	%	-	>85

※ 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 TRIECO 4D40G40 BK (OCEAN)

- General processing conditions for TRIECO 4D40G40 BK (OCEAN) are shown below.
- Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	100~120
Drying Time	hr	3 ~ 5
Moisture Content, Max	%	0.02
Melt Temperature	°C	260 ~ 280
Nozzle Temperature	°C	260 ~ 280
Front Temperature	°C	260 ~ 280
Middle Temperature	°C	260 ~ 280
Rear Temperature	°C	265 ~ 285
Mold Temperature	°C	60 ~ 80
Back Pressure	%	< 70
Screw Speed	%	< 60
Injection Pressure	%	< 70
Injection Speed	%	< 50
Hold Pressure	%	< 50
Injection Cushion	Mm	3 ~ 6

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