

Product Information

TRIECO 4D43G30 BK (OCEAN)

PA6/Eco plastic

TRIECO 4D43G30 BK (OCEAN)
contains a minimum of 28% ocean plastic.



TYPICAL DATA OF TRIECO 4D43G30 BK (OCEAN)

PROPERTY	UNIT	METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	ISO 1183	1.43
MECHANICAL			
Tensile Strength at yield	MPa	ISO 527	145
Tensile Elongation at break	%	ISO 527	2.5
Flexural Strength at yield	MPa	ISO 178	212
Flexural Modulus	MPa	ISO 178	>9030
Izod Impact Strength, notched, 23°C (1/8")	kJ/m ²	ISO 180	>8.5
Izod Impact Strength, notched, -30°C (1/8")	kJ/m ²	ISO 180	>8
THERMAL			
HDT, 1.82MPa	°C	ISO 75	202
HDT, 0.45MPa	°C	ISO 75	215
OTHERS			
Flammability (1.5mm)	Class	UL-94	V-0

※ 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 4D43G30 BK (OCEAN)

- General processing conditions for TRIECO 4D40G30 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	240 ~ 270
Nozzle Temperature	°C	240 ~ 270
Front Temperature	°C	240 ~ 270
Middle Temperature	°C	240 ~ 270
Rear Temperature	°C	235 ~ 265
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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