

Product Information

TRIECO 4D46M20 (OCEAN)

PA6/Eco plastic

TRIECO 4D46M20 BK (OCEAN)
contains a minimum of 36% ocean plastic.



TYPICAL DATA OF TRIECO 4D46M20 (OCEAN)

PROPERTY	UNIT	METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	ISO 1183	1.27
MECHANICAL			
Tensile Strength at yield	MPa	ISO 527	90
Tensile Elongation at break	%	ISO 527	2.5
Flexural Strength at yield	MPa	ISO 178	150
Flexural Modulus	MPa	ISO 178	>5000
Izod Impact Strength, notched, 23°C (1/8")	kJ/m ²	ISO 180	>10
Izod Impact Strength, notched, -30°C (1/8")	kJ/m ²	ISO 180	>5
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	ISO 75	190
OTHERS			
Mold Shrinkage	%	ASTM D955	<0.2

※ 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 4D46M20 (OCEAN)

- General processing conditions for TRIECO 4D46M20 (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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