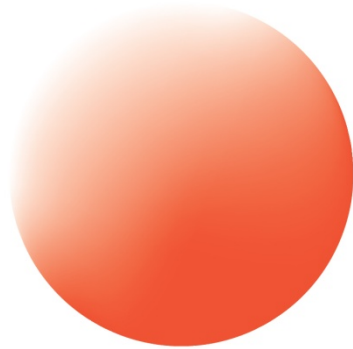


Product Information

TRIBIT[®] 1503(K)

Polybutylene terephthalate Resin



TYPICAL DATA OF TRIBIT 1503(K) GRADE

PROPERTY	UNIT	TEST METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	ISO 1183	1.30
Melt Flow Rate (235℃, 2.16kg)	g/10min	ISO 1133	14.0
MECHANICAL			
Tensile Strength at max load	MPa	ISO 527	52
Tensile Elongation at break	%	ISO 527	>40
Flexural Strength at yield	MPa	ISO 178	76.0
Flexural Modulus	MPa	ISO 178	2,150
Izod Impact Strength, notched, 23℃	KJ/m ²	ISO 180 / 1A	4.0
THERMAL			
HDT, 1.82 MPa, Flatwise	℃	ISO 75-2	52
HDT, 0.45 MPa, Flatwise	℃	ISO 75-2	118
OTHERS			
UL-94 Flammability	-	(UL 94)	-
Mold shrinkage (3mm thickness)	%	ASTM D955	1.4 ~ 2.2

※ 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 TRIBIT 1503(K) GRADE

- General processing conditions for TRIBIT 1503(K) are shown below.
- Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	120
Drying Time	hr	3 ~ 4
Moisture Content, Max	%	0.02
Melt Temperature	°C	250 ~ 260
Nozzle Temperature	°C	245 ~ 250
Front Temperature	°C	250 ~ 260
Middle Temperature	°C	245 ~ 255
Rear Temperature	°C	235 ~ 245
Mold Temperature	°C	60 ~ 80
Injection Pressure	%	<70
Injection Speed	%	<60
Hold Pressure	%	<70
Back Pressure	%	<50
Screw Speed	%	<60
Injection Cushion	mm	3 ~ 6