

TECHNICAL DATASHEET

TRIBIT[®] 1500GN20

PBT

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.61
Water Absorption (24 hours at 23°C)	%	D570	0.07
Melt Flow Rate (250°C/5kg)	g/10min	D1238	70
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,150
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg _f /cm ²	D790	1,600
Flexural Modulus	kg _f /cm ²	D790	60,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	6
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	205
Coefficient of Linear Thermal Expansion	mm/mm/°C	D696	3X10 ⁻⁵
ELECTRICAL			
Volume Resistivity	Ω·cm	D257	1X10 ¹⁶
Dielectric Strength	kV/mm	D149	20
Dielectric Constant	-	D150	3.1
Dissipation Factor	-	D150	0.02
ARC Resistance	sec	D495	120
OTHERS			
UL-94 Flammability (0.75mm thickness)	-	(UL 94)	V-0
Mold Shrinkage	%		0.2~1.2

※ 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

TRIBIT® 1500GN20 GRADE

PBT

- General processing conditions for TRIBIT1500GN20 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120
Drying Time	hr	3-5
Moisture Content, Max	%	0.02
Melt Temperature	℃	250-270
Nozzle Temperature	℃	245-265
Front Temperature	℃	250-270
Middle Temperature	℃	245-265
Rear Temperature	℃	240-260
Mold Temperature	℃	60-90
Back Pressure	MPa	<70
Screw Speed	rpm	<60
Injection Pressure	MPa	<70
Injection Speed	%	<50
Hold Pressure	MPa	<50
Injection Cushion	mm	3-6

Global Network

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