

TECHNICAL DATASHEET

TRIBIT[®] 1710

PBT

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.31
Water Absorption (24 hours at 23°C)	%	D570	0.1
Melt Flow Rate (260°C, 2.16kg)	g/10min	D1238	23
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	450
Tensile Elongation at break	%	D638	100
Flexural Strength at yield	kg _f /cm ²	D790	700
Flexural Modulus	kg _f /cm ²	D790	25,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	4
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	57
ELECTRICAL			
OTHERS			
UL-94 Flammability	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	1.4 ~ 2.3

※ 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® 1710 GRADE

PBT

- General processing conditions for TRIBIT1710 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	℃	250-260
Nozzle Temperature	℃	245-250
Front Temperature	℃	250-260
Middle Temperature	℃	245-255
Rear Temperature	℃	235-245
Mold Temperature	℃	60-80
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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