

TECHNICAL DATASHEET

TRIBIT[®] HR1503

PBT

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.30
Water Absorption (24 hours at 23℃)	%	D570	0.1
Melt Flow Rate	g/10min	D1238	15
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	500
Tensile Elongation at break	%	D638	110
Flexural Strength at yield	kg _f /cm ²	D790	800
Flexural Modulus	kg _f /cm ²	D790	24,000
Izod Impact Strength, notched, 23℃ (1/8")	kg _f ·cm/cm	D256	3
Rockwell Hardness	R scale	D785	118
THERMAL			
HDT, 18.6 kgf/cm ²	℃	D648	54
ELECTRICAL			
OTHERS			
Mold Shrinkage	%		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

TRIBIT[®] HR1503 GRADE

PBT

- General processing conditions for TRIBITHR1503 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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