

TECHNICAL DATASHEET

TRIBIT® LW1500G15K

PBT

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.45
Water Absorption (24 hours at 23°C)	%	D570	0.08
Melt Flow Rate (250°C/5kg)	g/10min	D1238	25
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	850
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	1,350
Flexural Modulus	kg _f /cm ²	D790	45,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	7
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	178
ELECTRICAL			
OTHERS			
UL-94 Flammability (1/6"mm thickness)	-	(UL 94)	HB
Mold Shrinkage	%		0.8~1.4

※ 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® LW1500G15K GRADE

PBT

- General processing conditions for TRIBITLW1500G15K are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120-130
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

HEAD OFFICE

Samyang Corporation
31, Jong-ro 33-gil, Jongno-gu, Seoul, Korea
T. +82-2-740-7747

Chemical Research Center

730, Daedeok-daero, Yuseong-gu, Daejeon, Korea
T. +82-42-865-8114

JEONJU ENGINEERING PLASTIC PLANT

147, Palbok-ro, Deokjin-gu, Jeonju, Korea
T. +82-63-210-6664

SAMYANG ENGINEERING PLASTICS (SHANGHAI) CO., LTD.

No.131, Shuangying Road, Qingpu Industrial Area,
Qingpu County, Shanghai, China
T. +86-21-6922-2270

SAMYANG ENGINEERING PLASTICS (HUNGARY) CO., LTD.

H5100, Jaszbereny, Necso, Telep 1, Hungary
T. +36-21-311-1263

SAMYANG ENGINEERING PLASTICS (VIETNAM) LLC

1 Song Hanh Road, Nhon Trach 6 Industrial Zone, Long Tho
Commune, Nhon Trach District, Dong Nai Province, Vietnam
T. +84-0251-3686-707