

TECHNICAL DATASHEET

TRIBIT[®] VS1503

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 (235℃/2.16kg)	g/10min	D1238	28
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	550
Tensile Elongation at break	%	D638	20
Flexural Strength at yield	kg _f /cm ²	D790	850
Flexural Modulus	kg _f /cm ²	D790	26,000
Izod Impact Strength, notched, 23℃ (1/8")	kg _f ·cm/cm	D256	4
THERMAL			
HDT, 18.6 kg _f /cm ²	℃	D648	60
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® VS1503 GRADE

PBT

- General processing conditions for TRIBITVS1503 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	℃	250-260
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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