TECHNICAL DATASHEET

TRIBIT® NEP1509GN30

PBT

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.59
Water Absorption (24 hours at 23℃)	%	D570	0.07
Melt Flow Rate	g/10min	D1238	40
MECHANICAL			
Tensile Strength at yield	$kg_f/㎠$	D638	1,000
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	$kg_f/㎠$	D790	1,600
Flexural Modulus	$kg_f/㎠$	D790	90,000
Izod Impact Strength, notched, 23℃ (1/8")	$kg_f·㎝/㎝$	D256	4
Rockwell Hardness	R scale	D785	120
THERMAL			
HDT, 18.6 ㎏f/㎠	℃	D648	208
ELECTRICAL			
OTHERS			
UL-94 Flammability	-	(UL 94)	V0
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® NEP1509GN30 GRADE

PBT

- General processing conditions for TRIBITNEP1509GN30 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	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~280
Nozzle Temperature	℃	250~280
Front Temperature	℃	250~280
Middle Temperature	℃	240~270
Rear Temperature	℃	230~260
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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