

PRODUCT CODE	TİSAKRİL I 20D03 R01
PRODUCT DESCRIPTION	ABS, 20% GLASS FIBER REINFORCED, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.20-1.25
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	0.5/0.5
	MOISTURE CONTENT	-	ISO 15512	%	<0.1

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	-
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	50-65
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	-
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	4000-5000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	5-6
	IZOD IMPACT STRENGTH, NOTCHED	-30°C	ISO 180/A	kJ/m ²	-
	IZOD IMPACT STRENGTH, UNNOTCHED	+23°C	ISO 180/U	kJ/m ²	-
	IZOD IMPACT STRENGTH, UNNOTCHED	-30°C	ISO 180/U	kJ/m ²	-

THERMAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	-
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	-
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	-
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	-
	BALL PRESSURE TEST	120 °C	ISO 60695-10-2	-	-

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ELECTRICAL&FLAMMABILITY	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	-
	FLAME RATING	1,6 mm	UL 94	-	-
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	-
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	-
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	-
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	1E+15
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+15

INJECTION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	80
	PREDRYING TIME	hours	2-4
	MELTING TEMPERATURE	°C	200-230
	NOZZLE TEMPERATURE	°C	200
	PRE-3 REGION TEMPERATURE	°C	200-220
	MID-2 REGION TEMPERATURE	°C	200-220
	AFT-1 REGION TEMPERATURE	°C	200-220
	MOLD TEMPERATURE	°C	60-80
	HOLD PRESSURE	MPa	50-100