

PRODUCT CODE	TISARBON H UNR R01
PRODUCT DESCRIPTION	PC, LOW TEMPERATURE IMPACT, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.19-1.22
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	0.6/0.8
	MOISTURE CONTENT	-	ISO 15512	%	<0.1

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	55-65
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	-
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	>50
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	2000-2500
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	60-70
	IZOD IMPACT STRENGTH, NOTCHED	-30°C	ISO 180/A	kJ/m ²	30-40
	IZOD IMPACT STRENGTH, UNNOTCHED	+23°C	ISO 180/U	kJ/m ²	NB
	IZOD IMPACT STRENGTH, UNNOTCHED	-30°C	ISO 180/U	kJ/m ²	NB

THERMAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	145
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	140
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	125
	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	-	HB
	FLAME RATING	1,6 mm	UL 94	-	HB
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	850
	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	90-120
	PREDRYING TIME	Hours	4-7
	MELTING TEMPERATURE	°C	270-300
	NOZZLE TEMPERATURE	°C	280-290
	PRE- 3 REGION TEMPERATURE	°C	260-270
	MID-2 REGION TEMPERATURE	°C	270-280
	AFT-1 REGION TEMPERATURE	°C	280-290
	MOLD TEMPERATURE	°C	70-120
	HOLD PRESSURE	MPa	60-120