

PRODUCT CODE	TISBLEND HI UNR F01 K02 HS R01
PRODUCT DESCRIPTION	PC/ABS, FLAME RETARDANT-HALOGEN (ROHS COMPLIANCE), NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.17-1.19
	MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	-
	MOISTURE CONTENT	-	ISO 15512	%	0.2

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

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	114
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	250-280
	BALL PRESSURE TEST	-	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	-	V0
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	960
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	-
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	-
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	1E+16
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+14

INJECTION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	80-100
	PREDRYING TIME	Hours	3-4
	MELTING TEMPERATURE	°C	-
	NOZZLE TEMPERATURE	°C	230-260
	PRE- 3 REGION TEMPERATURE	°C	240-260
	MID-2 REGION TEMPERATURE	°C	240-260
	AFT-1 REGION TEMPERATURE	°C	240-260
	MOLD TEMPERATURE	°C	70-90