

PRODUCT CODE	TISESTER F 25D03 F01 K02 HS R01
PRODUCT DESCRIPTION	PBT, 25% GLASS FIBER REINFORCED, FLAME RETARDANT-HALOGEN (RoHS COMPLIANCE), HEAT STABILIZED, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.58-1.61
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	0.3/1.0
	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	110-125
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	2-3
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	8000-9000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	8-10
	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	215
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	200
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	225
	BALL PRESSURE TEST	120 °C	ISO 60695-10-2	-	-

EL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
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FLAME RATING	0,75 mm	UL 94	-	V2
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	225
VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	1E+16
SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+14

INJECTION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	100-120
	PREDRYING TIME	hours	4-8
	MELTING TEMPERATURE	°C	250-270
	NOZZLE TEMPERATURE	°C	240-260
	PRE-3 REGION TEMPERATURE	°C	240-260
	MID-2 REGION TEMPERATURE	°C	230-250
	AFT-1 REGION TEMPERATURE	°C	230-240
	MOLD TEMPERATURE	°C	80-100
	HOLD PRESSURE	MPa	40-80