

<b>PRODUCT CODE</b>	<b>TISESTER F UNR K02 K04 R01</b>
<b>PRODUCT DESCRIPTION</b>	<b>PBT, UNREINFORCED, IMPACT MODIFIED, HEAT STABILIZED, NATURAL</b>

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm <sup>3</sup>	<b>1.32-1.34</b>
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	<b>1.70-2.50</b>
	MOISTURE CONTENT	-	ISO 15512	%	<b>&lt;0.20</b>

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	<b>40-50</b>
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	-
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	<b>&gt;10</b>
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	<b>1750-2500</b>
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m <sup>2</sup>	<b>7-10</b>
	IZOD IMPACT STRENGTH, NOTCHED	-30°C	ISO 180/A	kJ/m <sup>2</sup>	-
	IZOD IMPACT STRENGTH, UNNOTCHED	+23°C	ISO 180/U	kJ/m <sup>2</sup>	-
	IZOD IMPACT STRENGTH, UNNOTCHED	-30°C	ISO 180/U	kJ/m <sup>2</sup>	-

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	<b>225</b>
	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	-
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	-
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	600
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	10E+14
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	10E+15

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

Data are based on dry conditions

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