

<b>PRODUCT CODE</b>	<b>TISAKRİL I UNR F01 Y01 K02 K04 HS R01</b>
<b>PRODUCT DESCRIPTION</b>	<b>ABS, FLAME RETARDANT-HALOGEN (RoHS COMPLIANCE), HEAT STABILIZED, IMPACT MODIFIED, NATURAL</b>

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm <sup>3</sup>	<b>1.20-1.24</b>
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	<b>0.5/0.6</b>
	MOISTURE CONTENT	-	ISO 15512	%	<b>&lt;0.1</b>

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	-
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	<b>30-40</b>
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	<b>2-3</b>
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	<b>2000-3000</b>
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m <sup>2</sup>	<b>9-10</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	-
BALL PRESSURE TEST	120 °C	ISO 60695-10-2	-	-	

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<b>ELECTRICAL&amp;FLAMMABILITY</b>	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	<b>V0</b>
	FLAME RATING	1,6 mm	UL 94	-	<b>V0</b>
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	<b>960</b>
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	<b>900</b>
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	<b>225</b>
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	<b>1E+15</b>
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	<b>1E+15</b>

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

Data are based on dry conditions

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