TECHNICAL DATA SHEET

TİSESTER®

PRODUCT CODE	**TİSESTER F 30D03 K02 R01**
PRODUCT DESCRIPTION	**PBT, 30% GLASS FIBER REINFORCED, HEAT STABILIZED, NATURAL**

	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
PHYSICAL	DENSITY	-	ISO 1183	g/cm^3	**1.51-1.53**
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	**0.3/1.1**
	MOISTURE CONTENT	-	ISO 15512	%	**<0.1**

	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
MECHANICAL	YIELD STRENGTH	+23°C	ISO 527-2	MPa	**-**
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	**120-130**
	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	**8-11**
	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	**-**

	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
THERMAL	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	**-**
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	**220**
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	**205**
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	**225**
	BALL PRESSURE TEST	120 °C	ISO 60695-10-2	-	**-**

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ELECTRICAL&FLAMMABILITY	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	**-**
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	**1E+16**
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	**1E+14**

	PROPERTIES	UNITS	VALUE
INJECTION PROCESS	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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a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. It is the sole responsibility of the users investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Call Customer Services for the appropriate Material Safety Data Sheets (MSDS) before attempting to process our products.