

PRODUCT CODE	TİSESTER F UNR F01 K04 HS R01
PRODUCT DESCRIPTION	PBT, FLAME RETARDANT-HALOGEN (RoHS COMPLIANCE), IMPACT MODIFIED, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.38-1.40
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	1.6/1.6
	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	35-45
	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	7-9
	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	130
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	60
	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	-
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

Data are based on dry conditions

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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.