

PRODUCT CODE	TISBLEND HI UNR F02 Y01 R01
PRODUCT DESCRIPTION	PC/ABS FLAME RETARDANT(HALOGEN FREE), NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.19-1.21
	MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	
	MOISTURE CONTENT	-	ISO 15512	%	0.2

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	-
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	50-60
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	>35
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	2000-3000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	>35

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	100
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	-
BALL PRESSURE TEST	-	ISO 60695-10-2	-	-	

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ELECTRICAL & FLAMMABILITY	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	V0
	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	90-100
	PREDRYING TIME	hours	2-4
	MELTING TEMPERATURE	°C	255-270
	NOZZLE TEMPERATURE	°C	250-265
	PRE- 3 REGION TEMPERATURE	°C	250-270
	MID-2 REGION TEMPERATURE	°C	240-265
	AFT-1 REGION TEMPERATURE	°C	230-250
MOLD TEMPERATURE	°C	60-80	

Data are based on dry conditions

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