

<b>PRODUCT CODE</b>	<b>TISBLEND HI UNR K02 R01</b>
<b>PRODUCT DESCRIPTION</b>	<b>PC/ABS, HIGH HEAT STABILIZED, NATURAL</b>

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm <sup>3</sup>	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	55-65
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	>40
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	2500-3500
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m <sup>2</sup>	>40

THERMAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	140-145
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	135-140
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	-
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	-
	BALL PRESSURE TEST	-	ISO 60695-10-2	-	125

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<b>ELECTRICAL &amp; FLAMMABILITY</b>	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	<b>HB</b>
	FLAME RATING	1,6 mm	UL 94	-	<b>HB</b>
	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	<b>1E+16</b>
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	<b>1E+14</b>

<b>INJECTION PROCESS</b>	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	<b>90-100</b>
	PREDRYING TIME	hours	<b>2-4</b>
	MELTING TEMPERATURE	°C	<b>255-270</b>
	NOZZLE TEMPERATURE	°C	<b>250-265</b>
	PRE- 3 REGION TEMPERATURE	°C	<b>250-270</b>
	MID-2 REGION TEMPERATURE	°C	<b>240-265</b>
	AFT-1 REGION TEMPERATURE	°C	<b>230-250</b>
MOLD TEMPERATURE	°C	<b>60-80</b>	

Data are based on dry conditions

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