

Tisester® F 10D03 R01

PBT-GF10

Tisan Engineering Plastics Co.Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	4000	MPa	ISO 527
Stress at break	75	MPa	ISO 527
Strain at break	3.5	%	ISO 527
Izod notched impact strength, +23°C	6.5	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	180	°C	ISO 75-1/-2
Vicat softening temperature, B	200	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Electrical properties			
ISO Data			
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2
Other properties			
Density	1360	kg/m ³	ISO 1183
Moisture Content	0.1	%	-
Processing Recommendation Injection Molding			
Pre-drying - Temperature	110 - 120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-
Zone 1	230 - 240	°C	-
Zone 2	230 - 250	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	240 - 260	°C	-
Back pressure	3 - 10	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets, Natural Color

Regional Availability

Europe, Near East/Africa