Tisester® F 50D03 R01

PBT-GF50 — Tisan Engineering Plastics Co.Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.2**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.8**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**16000**	MPa	ISO 527
Stress at break	**140**	MPa	ISO 527
Strain at break	**2.5**	%	ISO 527
Izod notched impact strength, +23°C	**10**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**225**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**210**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**220**	°C	ISO 75-1/-2
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	Value	Unit	Test Standard
ISO Data			
Volume resistivity	**>1E13**	Ohm*m	IEC 62631-3-1
Surface resistivity	**1E14**	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	**1720**	kg/m³	ISO 1183
Moisture Content	**0.1**	%	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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