Tisarbon® H UNR K04 R01

PC — 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	**0.8**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2250**	MPa	ISO 527
Yield stress	**60**	MPa	ISO 527
Strain at break	**>50**	%	ISO 527
Izod impact strength, +23°C	**N**	kJ/m²	ISO 180/1U
Izod notched impact strength, +23°C	**65**	kJ/m²	ISO 180/1A
Izod notched impact strength	**35**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**125**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**140**	°C	ISO 75-1/-2
Vicat softening temperature, B	**145**	°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	Value	Unit	Test Standard
ISO Data			
Volume resistivity	**1E13**	Ohm*m	IEC 62631-3-1
Surface resistivity	**1E15**	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	**1210**	kg/m³	ISO 1183
Moisture Content	**0.1**	%	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**90 - 120**	°C	-
Pre-drying - Time	**4 - 7**	h	-
Melt temperature	**270 - 300**	°C	-
Mold temperature	**70 - 120**	°C	-
Zone 1	**280 - 290**	°C	-
Zone 2	**270 - 280**	°C	-
Zone 3	**260 - 270**	°C	-
Nozzle temperature	**280 - 290**	°C	-
Back pressure	**0.34 - 0.69**	MPa	-

Characteristics

Processing
Injection Molding

Special Characteristics
High impact or impact modified

Delivery form
Pellets, Natural Color

Regional Availability
Europe, Near East/Africa