

**Tisakril® I 10D03 R01**

ABS-GF10

Tisan Engineering Plastics Co.Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2000	MPa	ISO 527
Strain at break	>50	%	ISO 527
Izod notched impact strength, +23°C	17.5	kJ/m <sup>2</sup>	ISO 180/1A

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	1190	kg/m <sup>3</sup>	ISO 1183
Moisture Content	0.1	%	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	200 - 230	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	200 - 230	°C	-
Zone 2	200 - 230	°C	-
Zone 3	200 - 230	°C	-
Nozzle temperature	200	°C	-
Back pressure	0.1 - 0.5	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe, Near East/Africa

**Delivery form**

Pellets, Natural Color