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|----------------------------|---------------------------------------|
| <b>PRODUCT CODE</b>        | <b>TISBLEND IH UNR K03 R01</b>        |
| <b>PRODUCT DESCRIPTION</b> | <b>ABS/PC, UV STABILIZED, NATURAL</b> |

| PHYSICAL | PROPERTIES        | CONDITION       | STANDARD  | UNITS             | VALUE            |
|----------|-------------------|-----------------|-----------|-------------------|------------------|
|          | DENSITY           | -               | ISO 1183  | g/cm <sup>3</sup> | <b>1.13-1.15</b> |
|          | MOLDING SHRINKAGE | PARALLEL/NORMAL | ISO 294-4 | %                 | -                |
|          | MOISTURE CONTENT  | -               | ISO 15512 | %                 | <b>0.2</b>       |

| MECHANICAL | PROPERTIES                    | CONDITION | STANDARD  | UNITS             | VALUE            |
|------------|-------------------------------|-----------|-----------|-------------------|------------------|
|            | YIELD STRENGTH                | +23°C     | ISO 527-2 | MPa               | -                |
|            | TENSILE STRESS AT BREAK       | +23°C     | ISO 527-2 | MPa               | <b>50-53</b>     |
|            | TENSILE STRAIN AT BREAK       | +23°C     | ISO 527-2 | %                 | <b>4.5</b>       |
|            | TENSILE MODULUS               | +23°C     | ISO 527-2 | MPa               | <b>2000-2500</b> |
|            | IZOD IMPACT STRENGTH, NOTCHED | +23°C     | ISO 180/A | kJ/m <sup>2</sup> | <b>45</b>        |

| THERMAL | PROPERTIES                  | CONDITION | STANDARD       | UNITS | VALUE      |
|---------|-----------------------------|-----------|----------------|-------|------------|
|         | VICAT SOFTENING TEMPERATURE | 50 N      | ISO 306        | °C    | -          |
|         | HEAT DEFLECTION TEMPERATURE | 0,45 MPa  | ISO 75         | °C    | -          |
|         | HEAT DEFLECTION TEMPERATURE | 1,80 MPa  | ISO 75         | °C    | <b>108</b> |
|         | MELTING TEMPERATURE         | 10 K/min  | ISO 11357      | °C    | -          |
|         | BALL PRESSURE TEST          | -         | ISO 60695-10-2 | -     | -          |

|                            |                                       |
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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>80-100</b>  |
|                          | PREDRYING TIME            | Hours | <b>3-4</b>     |
|                          | MELTING TEMPERATURE       | °C    | -              |
|                          | NOZZLE TEMPERATURE        | °C    | <b>230-260</b> |
|                          | PRE- 3 REGION TEMPERATURE | °C    | <b>240-260</b> |
|                          | MID-2 REGION TEMPERATURE  | °C    | <b>240-260</b> |
|                          | AFT-1 REGION TEMPERATURE  | °C    | <b>240-260</b> |
|                          | MOLD TEMPERATURE          | °C    | <b>70-90</b>   |
|                          | HOLD PRESSURE             | MPa   | -              |