

PRODUCT CODE	TISBLEND IA 20D03 R01
PRODUCT DESCRIPTION	ABS/PA, 20% GLASS FIBER REINFORCED, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.17-1.22
	MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	-
	MOISTURE CONTENT	-	ISO 15512	%	0.2

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	-
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	70-80
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	4.5
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	4500-5000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	8-12

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	-
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	-
	BALL PRESSURE TEST	-	ISO 60695-10-2	-	-

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ELECTRICAL & FLAMMABILITY	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	HB
	FLAME RATING	1,6 mm	UL 94	-	HB
	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	1E+16
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+14

INJECTION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	80-90
	PREDRYING TIME	Hours	3-4
	MELTING TEMPERATURE	°C	-
	NOZZLE TEMPERATURE	°C	220-240
	PRE- 3 REGION TEMPERATURE	°C	210-230
	MID-2 REGION TEMPERATURE	°C	210-230
	AFT-1 REGION TEMPERATURE	°C	190-210
	MOLD TEMPERATURE	°C	60-90
	HOLD PRESSURE	MPa	-