

IUPIACE PX603Y
(PPE+PP)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	55	cm ³ /10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Molding shrinkage, parallel	1.1	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1900	MPa	ISO 527
Yield stress	42	MPa	ISO 527
Flexural modulus, 23°C	1900	MPa	ISO 178
Flexural strength	59	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	980	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110 - 120	°C	-
Pre-drying - Time	2 - 4	h	-
Mold temperature	60 - 100	°C	-
Zone 1	240 - 270	°C	-
Zone 2	250 - 290	°C	-
Zone 3	250 - 290	°C	-
Nozzle temperature	250 - 290	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa