Iupiace AP4GM6

(PPE+PS)-GF30 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**25**	cm³/10min	ISO 1133
Temperature	**280**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**0.2**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.3**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**7800**	MPa	ISO 527
Stress at break	**91**	MPa	ISO 527
Strain at break	**3.1**	%	ISO 527
Flexural modulus, 23°C	**7300**	MPa	ISO 178
Flexural strength	**145**	MPa	ISO 178
Charpy notched impact strength, +23°C	**6**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**115**	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**26**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**61**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**V-1**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Yellow Card available	**yes**	-	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	**3.5**	-	IEC 62631-2-1
Relative permittivity, 1MHz	**3.3**	-	IEC 62631-2-1
Dissipation factor, 100Hz	**92**	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	**77**	E-4	IEC 62631-2-1
Volume resistivity	**2E13**	Ohm*m	IEC 62631-3-1
Surface resistivity	**3E15**	Ohm	IEC 62631-3-2
Electric strength	**34**	kV/mm	IEC 60243-1
Comparative tracking index	**150**	-	IEC 60112

Other properties	Value	Unit	Test Standard
Water absorption	**0.06**	%	Sim. to ISO 62
Density	**1320**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**60 - 100**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Mold temperature	**80 - 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

Special Characteristics
Flame retardant

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