Iupiace GX1210

(PPE+PS)-GF35 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**9**	cm³/10min	ISO 1133
Temperature	**300**	°C	-
Load	**2.16**	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	**10500**	MPa	ISO 527
Stress at break	**115**	MPa	ISO 527
Strain at break	**2**	%	ISO 527
Flexural modulus, 23°C	**10500**	MPa	ISO 178
Flexural strength	**175**	MPa	ISO 178
Charpy notched impact strength, +23°C	**5**	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
Burning behav. at thickness h	**V-1**	class	IEC 60695-11-10
Thickness tested	**1.0**	mm	-
Yellow Card available	**yes**	-	-
Burning behav. 5V at thickness h	**5VB**	class	IEC 60695-11-20
Thickness tested	**2.7**	mm	-
Yellow Card available	**yes**	-	-

Other properties	Value	Unit	Test Standard
Water absorption	**0.06**	%	Sim. to ISO 62
Density	**1380**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100 - 120**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Mold temperature	**60 - 90**	°C	-
Zone 1	**260 - 280**	°C	-
Zone 2	**270 - 290**	°C	-
Zone 3	**280 - 300**	°C	-
Nozzle temperature	**280 - 300**	°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