

Iupiace TH620
(PPE+PS)-X20

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	5200	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	12	%	ISO 527
Flexural modulus, 23°C	5100	MPa	ISO 178
Flexural strength	100	MPa	ISO 178
Charpy notched impact strength, +23°C	4	kJ/m ²	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	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	0.06	%	Sim. to ISO 62
Density	1200	kg/m ³	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 - 280	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Features**

Low Warpage

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

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