

IUPIACE AHF6010B

(PPE+PS+PTFE)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	4.5	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	51	MPa	ISO 527
Yield strain	5	%	ISO 527
Strain at break	15	%	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	84	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	60	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	60	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	3E14	Ohm*m	IEC 62631-3-1
Surface resistivity	6E15	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Water absorption	0.06	%	Sim. to ISO 62
Density	1120	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 120	°C	-
Pre-drying - Time	2 - 4	h	-
Mold temperature	80 - 110	°C	-
Zone 1	240 - 260	°C	-
Zone 2	260 - 280	°C	-
Zone 3	260 - 280	°C	-
Nozzle temperature	260 - 280	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Additives

Lubricants

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

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

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Features

High Coefficient of Friction