

**Iupital F20-55R2**

POM

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	7.7	cm <sup>3</sup> /10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	62	MPa	ISO 527
Yield strain	8.5	%	ISO 527
Strain at break	30	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	6.5	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	100	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Yellow Card available	yes	-	-

Other properties	Value	Unit	Test Standard
Density	1410	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	60 - 80	°C	-
Zone 1	170	°C	-
Zone 2	180	°C	-
Zone 3	190	°C	-
Nozzle temperature	180 - 210	°C	-
Screw speed	80 - 120	rpm	-
Injection pressure	50 - 100	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

U.V. stabilized or stable to weather

**Features**

Low Emission, Copolymer

**Applications**

Automotive, Electrical and Electronical, General Purpose

**Regional Availability**

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