

Iupital F20-73R1

POM

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	7.9	cm ³ /10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Melt flow index, MFI	9.1	g/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
ISO Data			
Tensile Modulus	2900	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	8.5	%	ISO 527
Strain at break	30	%	ISO 527
Flexural modulus, 23°C	2610	MPa	ISO 178
Flexural strength	91	MPa	ISO 178
Charpy impact strength, +23°C	250	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
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
Temp. of deflection under load, 0.45 MPa	156	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	110	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Yellow Card available	yes	-	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.9	-	IEC 62631-2-1
Dissipation factor, 1MHz	70	E-4	IEC 62631-2-1
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	1E16	Ohm	IEC 62631-3-2
Electric strength	32	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

Other properties	Value	Unit	Test Standard
Humidity absorption	0.22	%	Sim. to ISO 62
Density	1410	kg/m ³	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	-

Iupital F20-73R1

POM

Mitsubishi Engineering-Plastics Corporation

Characteristics

Processing

Injection Molding

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