

Iupital F30-73R1

POM

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	23	cm ³ /10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Melt flow index, MFI	27	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	64	MPa	ISO 527
Yield strain	7.5	%	ISO 527
Strain at break	26	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	91	MPa	ISO 178
Charpy impact strength, +23°C	150	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	6	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
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
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	-

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