

**Iupital TC3030**

POM-MX30

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>6.9</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>190</b>	°C	-
Load	<b>2.16</b>	kg	-
Melt flow index, MFI	<b>9.5</b>	g/10min	ISO 1133
Temperature	<b>190</b>	°C	-
Load	<b>2.16</b>	kg	-
Molding shrinkage, parallel	<b>1.5</b>	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	<b>6900</b>	MPa	ISO 527
Stress at break	<b>62</b>	MPa	ISO 527
Strain at break	<b>3</b>	%	ISO 527
Flexural modulus, 23°C	<b>7000</b>	MPa	ISO 178
Flexural strength	<b>111</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>30</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>4</b>	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>166</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>144</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8</b>	mm	-
Yellow Card available	<b>yes</b>	-	-

Other properties	Value	Unit	Test Standard
Humidity absorption	<b>0.2</b>	%	Sim. to ISO 62
Density	<b>1630</b>	kg/m <sup>3</sup>	ISO 1183

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

**Characteristics****Processing**

Injection Molding

**Features**

Low Warpage, Copolymer

**Applications**

Automotive, Electrical and Electronical, General Purpose

**Regional Availability**

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