

**IUPIACE GX1050**

(PPE+PS)-GF20

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	24	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	6100	MPa	ISO 527
Stress at break	75	MPa	ISO 527
Strain at break	2.7	%	ISO 527
Flexural modulus, 23°C	6000	MPa	ISO 178
Flexural strength	122	MPa	ISO 178
Charpy notched impact strength, +23°C	5	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	105	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	37	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	68	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-1	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	3.0	mm	-
Yellow Card available	yes	-	-

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	5E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Comparative tracking index	175	-	IEC 60112

Other properties	Value	Unit	Test Standard
Water absorption	0.06	%	Sim. to ISO 62
Density	1250	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	60 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Mold temperature	80 - 100	°C	-
Zone 1	240 - 270	°C	-
Zone 2	250 - 290	°C	-
Zone 3	250 - 290	°C	-
Nozzle temperature	250 - 280	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive, Electrical and Electronical, General Purpose

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### Special Characteristics

Flame retardant

### Regional Availability

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