

[Product Information](#)
[Technical Service](#)
[Company Introduction](#)
[Environment · Safety](#)
[Inquiry](#)
[Membership Website](#)
[TOP PAGE](#) > [Product Information](#) > [Brands](#) > [Iupital](#) > Basic Properties

**Iupital -Basic Properties-**

				Standard -1
Properties	Test Method	Terms	Units	F30-03
				Low Viscosity
<b>Physical properties</b>				
Density	ISO 1183	-	g/cm <sup>3</sup>	1.41
Water absorption	-	23degC, 60%RH	%	0.22
<b>Rheological properties</b>				
Melt Mass-flow Rate	ISO 1133		g/10min	27
Melt Volume-flow Rate		Temperature	cm <sup>3</sup> /10min	23
		Load	degC	190
			kg	2.16
Moulding shrinkage (3mmt)	-	MD	%	2.0
		TD		-
<b>Mechanical properties</b>				
Tensile modulus	ISO 527-1	-	MPa	2900
Yield stress	, 527-2			64
Yield strain			%	7.5
Nominal strain at break				25
Stress at break			MPa	-
Strain at break			%	-
Flexural strength	ISO 178	-	MPa	91
Flexural modulus				2700
Charpy impact strength	ISO 179-1	23 degC	kJ/m <sup>2</sup>	150
Charpy notched impact strength	, 179-2	23 degC	kJ/m <sup>2</sup>	6.0
<b>Thermal properties</b>				
Melting temperature	ISO 11357-3		degC	166
Temperature of deflection under load	ISO 75-1	1.80MPa	degC	100
	, 75-2	0.45MPa		156
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/degC	1.1E-04
		TD		1.1E-04
Flammability	UL94	0.8mmt	-	HB
<b>Electrical properties</b>				
Relative permittivity	IEC 60250	100Hz	-	3.9
		1MHz	-	3.9
Dissipation factor	IEC 60250	100Hz	-	0.002
		1MHz	-	0.007
Volume resistivity	IEC 60093	-	ohm-m	1.E+12
Surface resistivity	IEC 60093	-	ohm	1.E+16
Electric strength	IEC 602431	1mmt	MV/m	32
		3mmt		19

Comparative tracking index	IEC 60112	-	-	600
Note				
<b>Molding conditions -Examples of recommended molding conditions are shown below.-</b>				
Drying of feedstock resin				Hot air drying at 80°C ---about 3-4 hours
Cylinder temp (rear)			°C	170
Cylinder temp (center)			°C	180
Cylinder temp (front)			°C	190
Nozzle temp			°C	180-210
Mold temp			°C	60-80
Injection pressure			MPa	50-100
Screw rotation			rpm	80-120
Injection speed			-	middle

The listed properties are portrayed as general information only and are not product specifications.  
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#### Product Info.



⌂ PAGE TOP