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Iupital -Basic Properties-

				Standard -1
Properties	Test Method	Terms	Units	F20-03 Medium Viscosity For General Molding
Physical properties				
Density	ISO 1183	-	g/cm ³	1.41
Water absorption	-	23degC, 60%RH	%	0.22
Rheological properties				
Melt Mass-flow Rate	ISO 1133	Temperature Load	g/10min	9.0
Melt Volume-flow Rate			cm ³ /10min	7.7
			degC	190
			kg	2.16
Moulding shrinkage (3mmt)	-	MD TD	%	2.0 -
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2	-	MPa	2900
Yield stress				64
Yield strain				%
Nominal strain at break				30
Stress at break			MPa	-
Strain at break			%	-
Flexural strength	ISO 178	-	MPa	90
Flexural modulus				2600
Charpy impact strength	ISO 179-1 , 179-2	23 degC	kJ/m ²	250
Charpy notched impact strength		23 degC		7.0
Thermal properties				
Melting temperature	ISO 11357-3		degC	166
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	100
		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
Electrical properties				
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				
Molding conditions -Examples of recommended molding conditions are shown below.-				
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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