

Iuplace™ TX903B

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information

Product Description

Creep resistance, good; Impact resistance, good

General

Features	• Creep Resistant	• Good Impact Resistance
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.09	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	2.5	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-1/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break)	40	%	ISO 527-2/50
Flexural Modulus ²	2350	MPa	ISO 178
Flexural Stress ²	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	32	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	145	°C	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	100 to 120	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	250 to 280	°C
Middle Temperature	270 to 300	°C
Front Temperature	270 to 300	°C
Nozzle Temperature	270 to 300	°C
Mold Temperature	80 to 110	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

