

Iuplace™ AHF6010B

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information			
Product Description			
Un-reinforced; Abrasion Resistant, Lubricant (PTFE 10%)			
General			
Additive	• PTFE Lubricant: 10%		
Features	• Abrasion Resistant	• Lubricated	
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	4.5	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	0.50 to 0.70	%	
Flow : 3.20 mm	0.50 to 0.70	%	
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)	51.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	5.0	%	
Break	15	%	
Flexural Modulus ²	2500	MPa	ISO 178
Flexural Stress ²	84.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	110	°C	
CLTE			ISO 11359-2
Flow	6.0E-5	cm/cm/°C	
Transverse	6.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94



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Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	80 to 120	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	240 to 260	°C
Middle Temperature	260 to 280	°C
Front Temperature	260 to 280	°C
Nozzle Temperature	260 to 280	°C
Mold Temperature	80 to 110	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

