

Iuplace™ TH620

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information			
Product Description			
Warpage, low			
General			
Filler / Reinforcement	• Filler, 20% Filler by Weight		
Features	• Low Warpage		
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	12	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	0.30 to 0.40	%	
Flow : 3.20 mm	0.30 to 0.40	%	
Water Absorption (Saturation, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5200	MPa	ISO 527-1/1
Tensile Stress (Break)	50.0	MPa	ISO 527-2/5
Tensile Strain (Break)	12	%	ISO 527-2/5
Flexural Modulus ²	5100	MPa	ISO 178
Flexural Stress ²	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	115	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.75 mm)	HB		UL 94
Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature - Hot Air Dryer	60 to 100	°C	
Drying Time - Hot Air Dryer	2.0 to 4.0	hr	
Rear Temperature	240 to 270	°C	
Middle Temperature	250 to 290	°C	
Front Temperature	250 to 290	°C	
Nozzle Temperature	250 to 280	°C	
Mold Temperature	80 to 100	°C	



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Injection	Nominal Value	Unit
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

