Mitsubishi Engineering-Plastics Corp.

Iupiace™ GH30

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information		
Product Description		
GF-reinforced / HB ; GF 30%		
General		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• Flame Retardant	
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.31	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	2.7	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	0.20 to 0.40	%	
Flow : 3.20 mm	0.10 to 0.20	%	
Water Absorption (Saturation, 23°C)	0.060	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	8900	MPa	ISO 527-1/1
Tensile Stress (Break)	103	MPa	ISO 527-2/5
Tensile Strain (Break)	1.3	%	ISO 527-2/5
Flexural Modulus [2]	8400	MPa	ISO 178
Flexural Stress [2]	170	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	8.0	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed	142	°C	ISO 75-2/B
1.8 MPa, Unannealed	130	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	2.5E-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
Electric Strength			IEC 60243-1
1.00 mm	30	kV/mm	
3.00 mm	17	kV/mm	
Comparative Tracking Index	150	V	IEC 60112

Iupiace™ GH30

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

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	100 to 120	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	260 to 290	°C
Middle Temperature	280 to 310	°C
Front Temperature	280 to 310	°C
Nozzle Temperature	270 to 310	°C
Mold Temperature	90 to 125	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm