

Iuplace™ AP6GM2

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information

Product Description

Flow, good; Reinforced (10%); Flame Retardant, V-1

General

Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight	
Additive	• Flame Retardant	
Features	• Flame Retardant	• Good Flow
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	28	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	0.30 to 0.50	%	
Flow : 3.20 mm	0.30 to 0.50	%	
Water Absorption (Saturation, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4000	MPa	ISO 527-1/1
Tensile Stress (Break)	65.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.9	%	ISO 527-2/5
Flexural Modulus ²	3800	MPa	ISO 178
Flexural Stress ²	116	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	95.0	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	4.7E-5	cm/cm/°C	
Transverse	5.8E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	5.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index	200	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	V-1		UL 94



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

