

Iupital™ ET-25

Mitsubishi Engineering-Plastics Corp - Acetal (POM) Copolymer

General Information

Product Description

Electrically conductive carbon added

General

Additive	• Carbon Black		
Features	• Electrically Conductive		
Uses	• Automotive Applications	• Electrical/Electronic Applications	
	• Automotive Electronics	• General Purpose	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	1.6	%	Internal Method
Water Absorption - 60% RH (23°C)	0.22	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-1/1
Tensile Stress (Yield)	51.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	5.0	%	
Break	10	%	
Flexural Modulus ²	2400	MPa	ISO 178
Flexural Stress ²	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	100	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	94.0	°C	
Melting Temperature	160	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	
Transverse	1.1E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	80	ohms	IEC 60093
Volume Resistivity	30	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94



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Processing Information		
Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	80	°C
Drying Time - Hot Air Dryer	3.0 to 4.0	hr
Rear Temperature	170	°C
Middle Temperature	180	°C
Front Temperature	190	°C
Nozzle Temperature	180 to 210	°C
Mold Temperature	40 to 80	°C
Injection Pressure	50.0 to 100	MPa
Injection Rate	Moderate	
Screw Speed	80 to 120	rpm

