

General Information

Product Description

Impact Resistance

General

Features	• Good Impact Resistance	• Soft
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	5.2	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.00 mm)	1.7	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1600	MPa	ISO 527-1/1
Tensile Stress (Yield)	39.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	12	%	
Break	> 100	%	
Flexural Modulus ²	1400	MPa	ISO 178
Flexural Stress ²	48.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	19	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	76.0	°C	
Melting Temperature	166	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	1.2E-4	cm/cm/°C	
Transverse	1.2E-4	cm/cm/°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94

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



Iupital™ FU2025

Mitsubishi Engineering-Plastics Corp - Acetal (POM) Copolymer

Injection	Nominal Value	Unit
Middle Temperature	180	°C
Front Temperature	190	°C
Nozzle Temperature	180 to 210	°C
Mold Temperature	< 40	°C
Injection Pressure	50.0 to 100	MPa
Injection Rate	Moderate	
Screw Speed	80 to 120	rpm

