

Iupital™ F20-55R2

Mitsubishi Engineering-Plastics Corp - Acetal (POM) Copolymer

General Information

Product Description

VOC, Low; Weather resistant

General

Features	• Good Weather Resistance	• Low VOC
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	7.7	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.00 mm)	2.0	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	8.5	%	
Break	30	%	
Flexural Modulus ²	2700	MPa	ISO 178
Flexural Stress ²	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.5	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	100	°C	ISO 75-2/A
Melting Temperature	166	°C	ISO 11357-3
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
Middle Temperature	180	°C
Front Temperature	190	°C
Nozzle Temperature	180 to 210	°C
Mold Temperature	60 to 80	°C
Injection Pressure	50.0 to 100	MPa
Injection Rate	Moderate	



Iupital™ F20-55R2
Mitsubishi Engineering-Plastics Corp - Acetal (POM) Copolymer

Injection	Nominal Value	Unit
Screw Speed	80 to 120	rpm

