

Iupiace® AH91

Polyphenylene Ether + PS

Mitsubishi Engineering-Plastics Corp

Message:

Iupiace® AH91 is a Polyphenylene Ether + PS (PPE+PS) material. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of Iupiace® AH91: Flame Rated.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	4.80	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.50 to 0.70	%	
Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2700	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	70.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	5.5	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	25	%	ISO 527-2
Flexural Modulus (23°C)	2700	MPa	ISO 178
Flexural Stress (23°C)	118	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	140	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	160	°C	ISO 75-2/B
1.8 MPa, Unannealed	145	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.6E-5	cm/cm/°C	
Transverse	6.9E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	2.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	

Drying Time	2.0 to 4.0	hr
Rear Temperature	250 to 280	°C
Middle Temperature	270 to 300	°C
Front Temperature	270 to 300	°C
Nozzle Temperature	270 to 300	°C
Mold Temperature	80.0 to 110	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

