

Iupiace® AHF6010B

Polyphenylene Ether + PS

Mitsubishi Engineering-Plastics Corp

Message:

Iupiace® AHF6010B is a Polyphenylene Ether + PS (PPE+PS) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupiace® AHF6010B are:

Flame Rated

Lubricated

Wear Resistant

General Information			
UL YellowCard	E41179-100828740	E41179-232002	
Additive	PTFE Lubricant (10%)		
Features	Good Wear Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	6.20	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)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	51.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	5.0	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	15	%	ISO 527-2
Flexural Modulus (23°C)	2500	MPa	ISO 178
Flexural Stress (23°C)	84.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	110	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.0E-5	cm/cm/°C	
Transverse	6.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.50 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 120	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	240 to 260	°C
Middle Temperature	260 to 280	°C
Front Temperature	260 to 280	°C
Nozzle Temperature	260 to 280	°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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