

Iuplace™ EHM1000 9905M2

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PS

General Information

Product Description

Electrically Conductive; Carbon black filled

General

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

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (320°C/5.0 kg)	12	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	0.70 to 0.90	%	
Flow : 3.20 mm	0.70 to 0.90	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-1/1
Tensile Stress (Break)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break)	9.0	%	ISO 527-2/5
Flexural Modulus ²	2500	MPa	ISO 178
Flexural Stress ²	102	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	159	°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	5.0E+3	ohms	IEC 60093

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	100 to 120	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	290 to 310	°C
Middle Temperature	310 to 330	°C
Front Temperature	310 to 330	°C
Nozzle Temperature	310 to 330	°C
Mold Temperature	110 to 130	°C
Injection Pressure	20.0 to 150	MPa

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Injection	Nominal Value	Unit
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 mm/min

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