

MIPS MI750

Injection Molding

Description

Impact Modified, High Gloss

Application

Electric/Electronic Components, Stationary Articles
Food Containers, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.05
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.8
Melt Flow Rate	200 °C/5kg	ASTM D1238(G)	g/10min	7
	220 °C/10kg	-	g/10min	81
	230 °C/3.8kg	ASTM D1238(I)	g/10min	18
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	380
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	5
@ Break	50mm/min		%	40
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	24,900
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	590
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	27,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg·cm/cm	5
	-30 °C		kg·cm/cm	3
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	7
	-30 °C		kg·cm/cm	4
Rockwell Hardness	R-Scale	ASTM D785	-	110
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	81
	4.6kg		°C	91
Vicat Softening Temperature	5kg, 50 °C/h	ASTM D1525	°C	93
Flammability		UL94		
	1.6mm		class	HB
	2.5mm		class	-
3.2mm			class	HB
Relative Temperature Index		UL 746B		
	Electrical		°C	-
	Mechanical with Impact		°C	-
	Mechanical without Impact		°C	-

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : 9-Nov-09

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80	
Drying Time	hrs	2 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	°C	190 ~ 220	
Cylinder Temperature	Rear	°C	170 ~ 190
	Middle	°C	180 ~ 200
	Front	°C	190 ~ 210
Nozzle Temperature	°C	190 ~ 220	
Mold Temperature	°C	40 ~ 70	
Back Pressure	kg/cm ²	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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