# Iupilon CGH1010R2

PC-(CF+GF)20 — Mitsubishi Engineering-Plastics Corporation

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| Melt volume-flow rate, MVR | **6.1** | cm³/10min | ISO 1133 |
| Temperature | **300** | °C | - |
| Load | **1.2** | kg | - |
| Melt flow index, MFI | **6.9** | g/10min | ISO 1133 |
| Temperature | **300** | °C | - |
| Load | **1.2** | kg | - |
| Molding shrinkage, parallel | **0.2** | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | **0.3** | % | ISO 294-4, 2577 |

| Mechanical properties | Value | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| Tensile Modulus | **7200** | MPa | ISO 527 |
| Stress at break | **91** | MPa | ISO 527 |
| Strain at break | **2** | % | ISO 527 |
| Flexural modulus, 23°C | **9000** | MPa | ISO 178 |
| Flexural strength | **180** | MPa | ISO 178 |
| Charpy impact strength, +23°C | **50** | kJ/m² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | **10** | kJ/m² | ISO 179/1eA |

| Thermal properties | Value | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| Temp. of deflection under load, 1.80 MPa | **143** | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | **148** | °C | ISO 75-1/-2 |
| Coeff. of linear therm. expansion, parallel | **24** | E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal | **59** | E-6/K | ISO 11359-1/-2 |
| Burning behav. at thickness h | **HB** | class | IEC 60695-11-10 |
| Thickness tested | **0.4** | mm | - |
| Yellow Card available | **yes** | - | - |

| Other properties | Value | Unit | Test Standard |
|---|---|---|---|
| Water absorption | **0.11** | % | Sim. to ISO 62 |
| Density | **1310** | kg/m³ | ISO 1183 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|---|---|---|
| Pre-drying - Temperature | **120** | °C | - |
| Pre-drying - Time | **4 - 8** | h | - |
| Mold temperature | **80 - 120** | °C | - |
| Zone 1 | **290 - 310** | °C | - |
| Zone 2 | **290 - 310** | °C | - |
| Zone 3 | **290 - 310** | °C | - |
| Nozzle temperature | **290 - 310** | °C | - |

## Characteristics

**Processing**

Injection Molding

**Applications**

General Purpose

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa