

**Iupilon CGH1020KR**

PC-(GF+CF)30

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	4.6	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	6.2	g/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	13000	MPa	ISO 527
Stress at break	127	MPa	ISO 527
Strain at break	1.7	%	ISO 527
Flexural modulus, 23°C	12500	MPa	ISO 178
Flexural strength	195	MPa	ISO 178
Charpy impact strength, +23°C	45	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	141	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	145	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	13	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	54	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	0.09	%	Sim. to ISO 62
Density	1380	kg/m <sup>3</sup>	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