

**Iupilon GS2010MN1**

PC-GF10

Mitsubishi Engineering-Plastics Corporation

| Processing/Physical Characteristics | Value | Unit                   | Test Standard   |
|-------------------------------------|-------|------------------------|-----------------|
| <b>ISO Data</b>                     |       |                        |                 |
| Melt volume-flow rate, MVR          | 9     | cm <sup>3</sup> /10min | ISO 1133        |
| Temperature                         | 300   | °C                     | -               |
| Load                                | 1.2   | kg                     | -               |
| Melt flow index, MFI                | 10    | g/10min                | ISO 1133        |
| Temperature                         | 300   | °C                     | -               |
| Load                                | 1.2   | kg                     | -               |
| Molding shrinkage, parallel         | 0.4   | %                      | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 0.5   | %                      | ISO 294-4, 2577 |

| Mechanical properties                 | Value | Unit              | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                       |       |                   |               |
| Tensile Modulus                       | 4500  | MPa               | ISO 527       |
| Stress at break                       | 78    | MPa               | ISO 527       |
| Strain at break                       | 2.9   | %                 | ISO 527       |
| Flexural modulus, 23°C                | 4000  | MPa               | ISO 178       |
| Flexural strength                     | 135   | MPa               | ISO 178       |
| Charpy impact strength, +23°C         | 55    | 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    | 140   | °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 | 40    | E-6/K | ISO 11359-1/-2  |
| Coeff. of linear therm. expansion, normal   | 67    | E-6/K | ISO 11359-1/-2  |
| Burning behav. at thickness h               | V-0   | class | IEC 60695-11-10 |
| Thickness tested                            | 0.8   | mm    | -               |
| Yellow Card available                       | yes   | -     | -               |

| Electrical properties      | Value | Unit | Test Standard |
|----------------------------|-------|------|---------------|
| <b>ISO Data</b>            |       |      |               |
| Comparative tracking index | 137   | -    | IEC 60112     |

| Other properties | Value | Unit              | Test Standard  |
|------------------|-------|-------------------|----------------|
| Water absorption | 0.14  | %                 | Sim. to ISO 62 |
| Density          | 1290  | 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

**Special Characteristics**

Flame retardant

**Regional Availability**

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