Iupilon GPF2040DF

PC-GF40 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**7.9**	cm³/10min	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	**0.1**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.1**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**11000**	MPa	ISO 527
Stress at break	**90**	MPa	ISO 527
Strain at break	**2**	%	ISO 527
Flexural modulus, 23°C	**10000**	MPa	ISO 178
Flexural strength	**150**	MPa	ISO 178
Charpy impact strength, +23°C	**23**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**5**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**110**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**115**	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**22**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**29**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Yellow Card available	**yes**	-	-
Burning behav. 5V at thickness h	**5VA**	class	IEC 60695-11-20
Thickness tested	**3.0**	mm	-
Yellow Card available	**yes**	-	-

Other properties	Value	Unit	Test Standard
Water absorption	**0.08**	%	Sim. to ISO 62
Density	**1510**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100**	°C	-
Pre-drying - Time	**4 - 8**	h	-
Mold temperature	**60 - 100**	°C	-
Zone 1	**280 - 300**	°C	-
Zone 2	**280 - 300**	°C	-
Zone 3	**280 - 300**	°C	-
Nozzle temperature	**280 - 300**	°C	-

Characteristics

Processing
Injection Molding

Features
Low Warpage

Additives
Flame retarding agent

Applications
General Purpose

Special Characteristics
Flame retardant

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