

**Iupilon CLV1000**

PC

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	7.4	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	7.9	g/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	5.5	%	ISO 527
Strain at break	110	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	93	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	84	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	131	°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	65	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	66	E-6/K	ISO 11359-1/-2

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Dissipation factor, 1MHz	90	E-4	IEC 62631-2-1
Volume resistivity	3E14	Ohm*m	IEC 62631-3-1
Surface resistivity	6E15	Ohm	IEC 62631-3-2
Electric strength	31	kV/mm	IEC 60243-1

Other properties	Value	Unit	Test Standard
Water absorption	0.24	%	Sim. to ISO 62
Density	1200	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	260 - 300	°C	-
Zone 2	260 - 300	°C	-
Zone 3	260 - 300	°C	-
Nozzle temperature	260 - 300	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Light stabilized or stable to light, U.V. stabilized or stable to weather, Transparent