

Iupilon H-4000

PC

Mitsubishi Engineering-Plastics Corporation

Product Texts

Optical Disk

Processing/Physical Characteristics

	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	60	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	63	g/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

Mechanical properties

	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	63	MPa	ISO 527
Yield strain	6.5	%	ISO 527
Strain at break	76	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	94	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA

Thermal properties

	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	123	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	136	°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
ISO Data			
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
Comparative tracking index	325	-	IEC 60112

Other properties

	Value	Unit	Test Standard
Water absorption	0.24	%	Sim. to ISO 62
Density	1200	kg/m ³	ISO 1183

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	50 - 130	°C	-
Zone 1	320 - 390	°C	-
Zone 2	320 - 390	°C	-
Zone 3	320 - 390	°C	-
Nozzle temperature	320 - 390	°C	-

Characteristics

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Processing

Injection Molding

Regional Availability

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