

**Iupilon HL-4002**

PC

Mitsubishi Engineering-Plastics Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>62</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Melt flow index, MFI	<b>65</b>	g/10min	ISO 1133
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Molding shrinkage, parallel	<b>0.5</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.5</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	<b>2400</b>	MPa	ISO 527
Yield stress	<b>65</b>	MPa	ISO 527
Yield strain	<b>5.6</b>	%	ISO 527
Strain at break	<b>96</b>	%	ISO 527
Flexural modulus, 23°C	<b>2500</b>	MPa	ISO 178
Flexural strength	<b>100</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>N</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>30</b>	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>121</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>134</b>	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	<b>65</b>	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	<b>66</b>	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	<b>V-2</b>	class	IEC 60695-11-10
Thickness tested	<b>0.4</b>	mm	-
Yellow Card available	<b>yes</b>	-	-

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Relative permittivity, 1MHz	<b>3.1</b>	-	IEC 62631-2-1
Dissipation factor, 1MHz	<b>90</b>	E-4	IEC 62631-2-1
Volume resistivity	<b>3E14</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>6E15</b>	Ohm	IEC 62631-3-2
Electric strength	<b>31</b>	kV/mm	IEC 60243-1
Comparative tracking index	<b>325</b>	-	IEC 60112

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Water absorption	<b>0.24</b>	%	Sim. to ISO 62
Density	<b>1200</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>110 - 120</b>	°C	-
Pre-drying - Time	<b>4 - 8</b>	h	-
Mold temperature	<b>80 - 120</b>	°C	-
Zone 1	<b>280 - 360</b>	°C	-
Zone 2	<b>280 - 360</b>	°C	-
Zone 3	<b>280 - 360</b>	°C	-
Nozzle temperature	<b>280 - 360</b>	°C	-

**Characteristics**

## Iupilon HL-4002

PC

Mitsubishi Engineering-Plastics Corporation

### Processing

Injection Molding

### Applications

IT / Business Machine, Electrical and Electronical

### Features

Light Guiding

### Regional Availability

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