Iupilon KH4210UR

PC — Mitsubishi Engineering-Plastics Corporation

Product Texts

High Surface Hardness (Clear), Pemcil Hardness F

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**57**	cm³/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Melt flow index, MFI	**59**	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
ISO Data			
Tensile Modulus	**2500**	MPa	ISO 527
Yield stress	**71**	MPa	ISO 527
Yield strain	**6**	%	ISO 527
Strain at break	**74**	%	ISO 527
Flexural modulus, 23°C	**2500**	MPa	ISO 178
Flexural strength	**103**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**3**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**111**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**124**	°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	**67**	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	**0.2**	%	Sim. to ISO 62
Density	**1180**	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	**250 - 300**	°C	-
Zone 2	**250 - 300**	°C	-
Zone 3	**250 - 300**	°C	-
Nozzle temperature	**250 - 300**	°C	-

Characteristics

Processing

Injection Molding

Applications

General Purpose

Regional Availability

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