

Iupilon S-1000U

PC

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	7.1	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	7.5	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	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 ²	ISO 179/1eU
Charpy notched impact strength, +23°C	84	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
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
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	80 - 110	°C	-
Zone 1	280 - 310	°C	-
Zone 2	280 - 310	°C	-
Zone 3	280 - 310	°C	-
Nozzle temperature	280 - 310	°C	-

Characteristics**Processing**

Injection Molding

Applications

General Purpose

Special Characteristics

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

Regional Availability

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