Iupilon GMB1110

(PC+Polyester)-GF10 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**8**	cm³/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Melt flow index, MFI	**9**	g/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Molding shrinkage, parallel	**0.4**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.4**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**4400**	MPa	ISO 527
Stress at break	**90**	MPa	ISO 527
Strain at break	**4**	%	ISO 527
Flexural modulus, 23°C	**4000**	MPa	ISO 178
Flexural strength	**135**	MPa	ISO 178
Charpy impact strength, +23°C	**50**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**8**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**136**	°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	**45**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**70**	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	**0.09**	%	Sim. to ISO 62
Density	**1290**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**4 - 8**	h	-
Mold temperature	**60 - 90**	°C	-
Zone 1	**270 - 290**	°C	-
Zone 2	**270 - 290**	°C	-
Zone 3	**270 - 290**	°C	-
Nozzle temperature	**270 - 290**	°C	-

Characteristics

Processing

Injection Molding

Applications

Automotive, General Purpose

Chemical Resistance

General Chemical Resistance

Regional Availability

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