

**Iupilon ECF2020R**

PC-CF20

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	14000	MPa	ISO 527
Stress at break	140	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	12500	MPa	ISO 178
Flexural strength	190	MPa	ISO 178
Charpy impact strength, +23°C	50	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	146	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	151	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Yellow Card available	yes	-	-

Other properties	Value	Unit	Test Standard
Water absorption	0.09	%	Sim. to ISO 62
Density	1280	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	80 - 120	°C	-
Zone 1	280 - 300	°C	-
Zone 2	280 - 300	°C	-
Zone 3	280 - 300	°C	-
Nozzle temperature	280 - 300	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Flame retardant, Phosphorus-free

**Applications**

General Purpose

**Regional Availability**

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