

Iupilon GSH3120R

PC-GF20

Mitsubishi Engineering-Plastics Corporation

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|-------|------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.2 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.4 | % | ISO 294-4, 2577 |

| Mechanical properties | Value | Unit | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 6800 | MPa | ISO 527 |
| Stress at break | 121 | MPa | ISO 527 |
| Strain at break | 2.5 | % | ISO 527 |
| Flexural modulus, 23°C | 6600 | MPa | ISO 178 |
| Flexural strength | 178 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 57 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 11 | kJ/m ² | ISO 179/1eA |

| Thermal properties | Value | Unit | Test Standard |
|---|-------|-------|-----------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 141 | °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 | 25 | E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal | 60 | E-6/K | ISO 11359-1/-2 |
| Burning behav. at thickness h | HB | class | IEC 60695-11-10 |
| Thickness tested | 0.4 | mm | - |
| Yellow Card available | yes | - | - |

| Other properties | Value | Unit | Test Standard |
|------------------|-------|-------------------|----------------|
| Water absorption | 0.11 | % | Sim. to ISO 62 |
| Density | 1320 | 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 - 120 | °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

Regional Availability

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