

Iupilon MB1800

(PC+ABS)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	14	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Melt flow index, MFI	14	g/10min	ISO 1133
Temperature	260	°C	-
Load	2.16	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	2800	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	4	%	ISO 527
Strain at break	92	%	ISO 527
Flexural modulus, 23°C	2800	MPa	ISO 178
Flexural strength	95	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	40	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	81	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	89	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	1.2	mm	-
Yellow Card available	yes	-	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	2.0	mm	-
Yellow Card available	yes	-	-

Other properties	Value	Unit	Test Standard
Water absorption	0.2	%	Sim. to ISO 62
Density	1180	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	50 - 70	°C	-
Zone 1	230 - 270	°C	-
Zone 2	230 - 270	°C	-
Zone 3	230 - 270	°C	-
Nozzle temperature	230 - 270	°C	-

Characteristics**Processing**

Injection Molding

Additives

Flame retarding agent

Special Characteristics

Flame retardant

Applications

Electrical and Electronical, General Purpose

Regional Availability

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