Iupilon MB2212R

(PC+ABS) Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**10**	cm³/10min	ISO 1133
Temperature	**250**	°C	-
Load	**2.16**	kg	-
Melt flow index, MFI	**11**	g/10min	ISO 1133
Temperature	**250**	°C	-
Load	**2.16**	kg	-
Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.5**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2500**	MPa	ISO 527
Yield stress	**55**	MPa	ISO 527
Yield strain	**4.4**	%	ISO 527
Strain at break	**46**	%	ISO 527
Flexural modulus, 23°C	**2400**	MPa	ISO 178
Flexural strength	**88**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**70**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**96**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**114**	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**70**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**70**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Yellow Card available	**yes**	-	-

Other properties	Value	Unit	Test Standard
Water absorption	**0.12**	%	Sim. to ISO 62
Density	**1120**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 100**	°C	-
Pre-drying - Time	**4 - 8**	h	-
Mold temperature	**60 - 90**	°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

Applications
General Purpose

Features
Low Emission

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