

Iupilon MB2219R

(PC+ABS)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	9	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Melt flow index, MFI	9	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	57	MPa	ISO 527
Yield strain	4.8	%	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	91	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	60	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	130	°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	1140	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	60 - 90	°C	-
Zone 1	240 - 290	°C	-
Zone 2	240 - 290	°C	-
Zone 3	240 - 290	°C	-
Nozzle temperature	240 - 290	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Applications

General Purpose

Regional Availability

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