Iupilon MB2223R

(PC+ABS) Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**5**	cm³/10min	ISO 1133
Temperature	**250**	°C	-
Load	**2.16**	kg	-
Melt flow index, MFI	**5**	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	**2300**	MPa	ISO 527
Yield stress	**51**	MPa	ISO 527
Yield strain	**4.7**	%	ISO 527
Strain at break	**50**	%	ISO 527
Flexural modulus, 23°C	**2200**	MPa	ISO 178
Flexural strength	**80**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**60**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**102**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**124**	°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

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	**90 - 100**	°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

Applications

General Purpose

Special Characteristics

High impact or impact modified

Regional Availability

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