

**Iupilon MB4306R**

(PC+Polyester)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	24	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	25	g/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	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
<b>ISO Data</b>			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	59	MPa	ISO 527
Yield strain	4.8	%	ISO 527
Strain at break	110	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	58	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	100	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	112	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	68	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	68	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Density	1230	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	60 - 90	°C	-
Zone 1	270 - 290	°C	-
Zone 2	270 - 290	°C	-
Zone 3	270 - 290	°C	-
Nozzle temperature	270 - 290	°C	-

**Characteristics****Processing**

Injection Molding

**Chemical Resistance**

General Chemical Resistance

**Applications**

General Purpose

**Regional Availability**

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