Iupilon MB4308

(PC+Polyester) Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**12**	cm³/10min	ISO 1133
Temperature	**280**	°C	-
Load	**2.16**	kg	-
Melt flow index, MFI	**13**	g/10min	ISO 1133
Temperature	**280**	°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	**62**	MPa	ISO 527
Yield strain	**4.7**	%	ISO 527
Strain at break	**140**	%	ISO 527
Flexural modulus, 23°C	**2200**	MPa	ISO 178
Flexural strength	**94**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**57**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**97**	°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	**1210**	kg/m³	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

Applications

General Purpose

Chemical Resistance

General Chemical Resistance

Regional Availability

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