Mitsubishi Engineering-Plastics Corp.

Iupilon™ GSH2030DF

Mitsubishi Engineering-Plastics Corp - Polycarbonate

General Information	
Product Description	
Reinforced (30%), Low Warpage	
General	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Low Warpage
Uses	• General Purpose

ASTM & ISO Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.43	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.9	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	5.2	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.10 to 0.30	%	
Flow	0.10 to 0.30	%	
Water Absorption (Saturation, 23°C)	0.090	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	7300	MPa	ISO 527-1/1
Tensile Stress (Break)	80.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus [2]	6800	MPa	ISO 178
Flexural Stress [2]	137	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	5.0	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	34	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed	142	°C	ISO 75-2/B
1.8 MPa, Unannealed	136	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	2.7E-5	cm/cm/°C	
Transverse	4.5E-5	cm/cm/°C	
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index (CTI)	PLC 4		UL 746A
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.40 mm)	HB		UL 94

Iupilon™ GSH2030DF

Mitsubishi Engineering-Plastics Corp - Polycarbonate

Processing Information		
Injection	**Nominal Value**	**Unit**
Drying Temperature - Hot Air Dryer	120	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	290 to 310	°C
Middle Temperature	290 to 310	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	290 to 310	°C
Mold Temperature	80 to 120	°C