

Iupilon™ KH4210UR

Mitsubishi Engineering-Plastics Corp - Polycarbonate

General Information

Product Description

High Surface hardness (Clear), Pencil Hardness F

General

Features	• High Hardness
Uses	• General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	59	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	57	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (24 hr, 23°C)	0.20	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-1/1
Tensile Stress (Yield)	71.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	6.0	%	
Break	74	%	
Flexural Modulus ²	2500	MPa	ISO 178
Flexural Stress ²	103	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	124	°C	ISO 75-2/B
1.8 MPa, Unannealed	111	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	
Transverse	6.7E-5	cm/cm/°C	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	100	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	250 to 300	°C



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Injection	Nominal Value	Unit
Middle Temperature	250 to 300	°C
Front Temperature	250 to 300	°C
Nozzle Temperature	250 to 300	°C
Mold Temperature	60 to 100	°C

