

Iupilon™ LSH2020

Mitsubishi Engineering-Plastics Corp - Polycarbonate

General Information			
Product Description			
Wear Resistance Improved, Fluorine resin 10%			
General			
Additive	• PTFE Lubricant: 10%		
Features	• Abrasion Resistant	• Wear Resistant	
Uses	• General Purpose		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.3	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-1/1
Tensile Stress (Yield)	53.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	6.6	%	
Break	100	%	
Flexural Modulus ²	2300	MPa	ISO 178
Flexural Stress ²	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	kJ/m²	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	142	°C	ISO 75-2/B
1.8 MPa, Unannealed	126	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.6E-5	cm/cm/°C	
Transverse	7.0E-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



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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	280 to 300	°C
Middle Temperature	280 to 300	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 300	°C
Mold Temperature	70 to 100	°C

