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Iupilon -PC-

				Light Diffusion
Properties	Test Method	Terms	Units	DS3002R 7031A
				Light Diffusion Medium class
				-
				-
				-
Physical properties				
Density	ISO 1183	-	g/cm³	1.20
Water absorption		23degC, 50%RH	%	-
		23degC, Underwater		0.24
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	14
Melt Volume-flow Rate		Temperature Load	cm³/10min degC	14 300
			kgf	1.20
Moulding shrinkage (3.2mmt)	-	MD	%	0.5 - 0.7
		TD		0.5 - 0.7
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2		MPa	2500
Yield stress				59
Yield strain			%	6.5
Nominal strain at break		-		112
Stress at 50% strain			MPa	-
Stress at break				-
Strain at break			%	-
Flexural strength	ISO 178	-	MPa	89
Flexural modulus				2300
Charpy impact strength	ISO 179-1, 179-2	23 degC	kJ/m²	NB
Charpy notched impact strength	ISO 179-1, 179-2	23 degC	kJ/m²	9
Thermal properties				
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	123
		0.45MPa		136
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/degC	6.5E-05
		TD		6.6E-05
Flammability	UL94	-	-	V-2(0.4mm)
Electrical properties				
Relative permittivity	IEC 60250	100Hz	-	-
		1MHz	-	-
Dissipation factor	IEC 60250	100Hz	-	-
		1MHz	-	-
Volume resistivity	IEC 60093	-	ohm-m	3E+14

Surface resistivity	IEC 60093	-	ohm	6E+15
Electric strength	IEC 60243-1	1mmt	MV/m	-
		2mmt		-
		3mmt		-
Comparative tracking index (CTI)	UL746A	-	-	2
Note				
Molding conditions -Examples of recommended molding conditions are shown below.-				
Drying of feedstock resin				Hot air drying at 120°C---about 4-8 hours
Cylinder temp (rear)			°C	260-280
Cylinder temp (center)			°C	270-290
Cylinder temp (front)			°C	270-300
Nozzle temp			°C	270-300
Mold temp			°C	70-100
Injection pressure			MPa	50-150
Screw rotation			rpm	50-100

