Iupilon -Basic Properties-

				for Lens of glasses
Properties	Test Method	Terms	Units	CLS1000
				High Viscosity Light stabilized
				-
				-
				-
Physical properties				
Density	ISO 1183	-	g/cm^3	1.20
Water absorption		23degC, 50%RH	%	-
		23degC, Underwater		0.24
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	5.3
Melt Volume-flow Rate			cm^3/10min	5.0
		Temperature	degC	300
		Load	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	2400
Yield stress				60
Yield strain			%	5.4
Nominal strain at break		-		108
Stress at 50% strain			MPa	-
Stress at break				-
Strain at break			%	-
Flexural strength	ISO 178	-	MPa	93
Flexural modulus				2300
Charpy impact strength	ISO 179-1 , 179-2	23 degC	kJ/m^2	NB
Charpy notched impact strength		23 degC	kJ/m^2	88
Thermal properties				
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	131
		0.45MPa		145
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/degC	6.5E-05
		TD		6.6E-05
Flammability	UL94	-	-	-
Electrical properties				
Relative permittivity	IEC 60250	100Hz	-	3.1
		1MHz	-	3.1
Dissipation factor	IEC 60250	100Hz	-	0.0006
		1MHz	-	0.0090
Volume resistivity	IEC 60093	-	ohm-m	3.E+14
Surface resistivity	IEC 60093	-	ohm	6.E+15

Electric strength	IEC 602431	1mmt 2mmt 3mmt	MV/m	31 - 18
Comparative tracking index (CTI)	UL746A	-	-	-
Note				Cut UV of under 380nm at 3mmt
Molding conditions -Examples of recommended molding conditions are shown below.-				
Drying of feedstock resin				Hot air drying at 120℃---about 4-8 hours
Cylinder temp (rear)			℃	260-280
Cylinder temp (center)			℃	270-290
Cylinder temp (front)			℃	270-300
Nozzle temp			℃	270-300
Mold temp			℃	80-120
Injection pressure			MPa	50-150
Screw rotation			rpm	50-100