

lupilon-PC-

				Light guide Grade	
Properties	Test Method	Terms	Units	HL-7001	HL-8000
				Super high flow High luminance	Super high flow High luminance
				—	—
				—	—
				—	—
Physical properties					
Density	ISO 1183	—	g/cm3	1.20	1.20
Water absorption		23degC, 50%RH	%	—	—
		23degC, Underwater		0.24	0.24
Rheological properties					
Melt Mass-flow Rate	ISO 1133		g/10min	113	139
Melt Volume-flow Rate		Temperature Load	cm3/10min	108	136
			degC	300	300
			kgf	1.20	1.20
Moulding shrinkage (3.2mmt)	—	MD	%	0.4 – 0.6	0.4 – 0.6
		TD		0.4 – 0.6	0.4 – 0.6
Mechanical properties					
Tensile modulus	ISO 527-1 , 527-2		MPa	2300	2400
Yield stress				64	65
Yield strain			%	5.5	5.7
Nominal strain at break		—			87

Stress at 50% strain			MPa	–	–
Stress at break				–	–
Strain at break			%	–	–
Flexural strength	ISO 178	–	MPa	100	100
Flexural modulus				2500	2500
Charpy impact strength	ISO 179-1, 179-2	23 degC	kJ/m2	NB	NB
Charpy notched impact strength	ISO 179-1, 179-2	23 degC	kJ/m2	12	9
Thermal properties					
Temperature of deflection under load	ISO 75-1, 75-2	1.80MPa 0.45MPa	degC	118 132	118 132
Coefficient of Linear thermal expansion	ISO 11359-2	MD TD	1/degC	6.5E-05 6.6E-05	6.5E-05 6.6E-05
Flammability	UL94	–	–	V-2 (0.38mm)	V-2 (0.38mm)
Electrical properties					
Relative permittivity	IEC 60250	100Hz	–	3.1	3.1
		1MHz	–	3.1	3.1
Dissipation factor	IEC 60250	100Hz	–	0.0006	0.0006
		1MHz	–	0.009	0.009
Volume resistivity	IEC 60093	–	ohm-m	3E+14	3E+14
Surface resistivity	IEC 60093	–	ohm	6E+15	6E+15
Electric strength	IEC 60243-1	1mmt	MV/m	31	31
		2mmt		–	–
		3mmt		18	18
Comparative tracking index (CTI)	UL746A	–	–	2	–

Note					HL-8002 (YI Stabilized)
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)			℃	260-320	260-320
Cylinder temp (center)			℃	270-330	270-330
Cylinder temp (front)			℃	280-340	280-340
Nozzle temp			℃	280-340	280-340
Mold temp			℃	80-120	80-120
Injection pressure			MPa	50-150	50-150
Screw rotation			rpm	50-150	50-150

The listed properties are portrayed as general information only and are not product specifications.
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