

Iupilon-PC-

				Gamma-ray Resistance
Properties	Test Method	Terms	Units	RS-1001R
				Gamma-ray Resistance
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				—
				—
Physical properties				
Density	ISO 1183	—	g/cm ³	1.21
Water absorption		23degC, 50%RH 23degC, Underwater	%	— 0.24
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	8
Melt Volume-flow Rate		Temperature	cm ³ /10min	7
		Load	degC kgf	300 1.20
Moulding shrinkage (3.2mmt)	—	MD TD	%	0.5 - 0.7 0.5 - 0.7
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2		MPa	2200
Yield stress				62
Yield strain			%	6.3
Nominal strain at break		—		100
Stress at 50% strain			MPa	—
Stress at break				—
Strain at break			%	—
Flexural strength	ISO 178	—	MPa	93
Flexural modulus				2200
Charpy impact strength	ISO 179-1, 179-2	23 degC	kJ/m ²	NB



Charpy notched impact strength	ISO 179-1, 179-2	23 degC	kJ/m ²	78
Thermal properties				
Temperature of deflection under load	ISO 75-1, 75-2	1.80MPa 0.45MPa	degC	128 141
Coefficient of Linear thermal expansion	ISO 11359-2	MD TD	1/degC	6.5E-05 6.6E-05
Flammability	UL94	—	—	—
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 2mmt 3mmt	MV/m	— — —
Comparative tracking index (CTI)	UL746A	—	—	—
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

