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Iupilon -Basic Properties-

				Polymer Alloy (PC/POLYESTER)-1
Properties	Test Method	Terms	Units	MB5002R
				Long Lasting Anti-static
				-
				-
				-
Physical properties				
Density	ISO 1183	-	g/cm³	1.20
Water absorption		23degC, 50%RH	%	-
		23degC, Underwater	8	0.20
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	10
Melt Volume-flow Rate		Temperature Load	cm³/10min	9.2
			degC	300
			kgf	1.20
Moulding shrinkage (3.2mmt)	-	MD	%	0.6 - 0.8
		TD		0.6 - 0.8
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2		MPa	2100
Yield stress				50
Yield strain			%	5.9
Nominal strain at break		-		140
Stress at 50% strain			MPa	-
Stress at break				-
Strain at break			%	-
Flexural strength	ISO 178	-	MPa	78
Flexural modulus				2000
Charpy impact strength	ISO 179-1 , 179-2	23 degC	kJ/m²	NB
Charpy notched impact strength		23 degC	kJ/m²	80
Thermal properties				
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	112
		0.45MPa		132
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/degC	8.0E-05
		TD		9.6E-05
Flammability	UL94	-	-	-
Electrical properties				
Relative permittivity	IEC 60250	100Hz	-	4.4
		1MHz	-	3.5
Dissipation factor	IEC 60250	100Hz	-	0.0081
		1MHz	-	0.0233
Volume resistivity	IEC 60093	-	ohm-m	3.E+11
Surface resistivity	IEC 60093	-	ohm	7.E+11

Electric strength	IEC 602431	1mmt	MV/m	-
		2mmt		24
		3mmt		18
Comparative tracking index (CTI)	UL746A	-	-	-
Note				MB5002UR UV 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)			℃	250-270
Cylinder temp (center)			℃	260-280
Cylinder temp (front)			℃	270-290
Nozzle temp			℃	270-290
Mold temp			℃	60-90
Injection pressure			MPa	50-150
Screw rotation			rpm	50-100

