

Iupilon® MB2215R

Acrylonitrile Butadiene Styrene + PC

Mitsubishi Engineering-Plastics Corp

Technical Data

Product Description

Iupilon® MB2215R is an Acrylonitrile Butadiene Styrene + PC (ABS+PC) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® MB2215R are:

- Flame Rated
- Weldable

General

Features	• Weldable
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.13 g/cm ³	1.13 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.7 g/10 min	4.7 g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	0.269 in ³ /10min	4.40 cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 0.126 in (3.20 mm)	0.40 to 0.60 %	0.40 to 0.60 %	
Flow : 0.126 in (3.20 mm)	0.40 to 0.60 %	0.40 to 0.60 %	
Water Absorption (Saturation, 73°F (23°C))	0.12 %	0.12 %	ISO 62

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	348000 psi	2400 MPa	ISO 527-2
Tensile Stress (Yield)	7540 psi	52.0 MPa	ISO 527-2
Tensile Strain (Yield)	5.1 %	5.1 %	ISO 527-2
Nominal Tensile Strain at Break	51 %	51 %	ISO 527-2
Flexural Modulus	334000 psi	2300 MPa	ISO 178
Flexural Strength	12300 psi	85.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	29 ft-lb/in ²	60 kJ/m ²	ISO 179
Charpy Unnotched Impact Strength 73°F (23°C)	No Break	No Break	ISO 179

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	253 °F	123 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	212 °F	100 °C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	0.000039 in/in/°F	0.000070 cm/cm/°C	
Transverse	0.000039 in/in/°F	0.000070 cm/cm/°C	

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.0591 in (1.50 mm))	HB	HB	UL 94

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 212 °F	80.0 to 100 °C
Drying Time	4.0 to 8.0 hr	4.0 to 8.0 hr
Rear Temperature	410 to 482 °F	210 to 250 °C



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Injection	Nominal Value (English)	Nominal Value (SI)
Middle Temperature	428 to 500 °F	220 to 260 °C
Front Temperature	446 to 518 °F	230 to 270 °C
Nozzle Temperature	446 to 518 °F	230 to 270 °C
Mold Temperature	140 to 194 °F	60.0 to 90.0 °C
Injection Pressure	7250 to 21800 psi	50.0 to 150 MPa
Screw Speed	50 to 100 rpm	50 to 100 rpm

