

Iupilon-PC-

				Flame Retardant-1
Properties	Test Method	Terms	Units	N-9
				Bromine
				Clear
				Extrusion
				—
				—
				—
Physical properties				
Density	ISO 1183	—	g/cm3	1. 31
Water absorption		23degC, 50%RH	%	—
		23degC, Underwater		0. 17
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	3. 3
Melt Volume-flow Rate		Temperature Load	cm3/10min	2. 9
			degC	300
Moulding shrinkage (3.2mmt)	—	MD	kgf	1. 20
		TD	%	0. 5 - 0. 7
				0. 5 - 0. 7
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2		MPa	2600
Yield stress				68
Yield strain			%	7. 2
Nominal strain at break		—		90
Stress at 50% strain			MPa	—

Stress at break				—
Strain at break			%	—
Flexural strength	ISO 178	—	MPa	98
Flexural modulus				2300
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	11
Thermal properties				
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	137
		0.45MPa		151
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/degC	6.3E-05
		TD		6.2E-05
Flammability	UL94	—	—	V-0 (0.8mm)
Electrical properties				
Relative permittivity	IEC 60250	100Hz	—	3.1
		1MHz	—	3.0
Dissipation factor	IEC 60250	100Hz	—	0.0008
		1MHz	—	0.0079
Volume resistivity	IEC 60093	—	ohm-m	4E+14
Surface resistivity	IEC 60093	—	ohm	3E+15
Electric strength	IEC 60243-1	1mmt	MV/m	—
		2mmt		—
		3mmt		—
Comparative tracking index (CTI)	UL746A	—	—	2
Note				N-9R (Mold Release)

				N-9U(R) (UV Stabilized)
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	280-310
Nozzle temp			°C	280-310
Mold temp			°C	80-110
Injection pressure			MPa	50-150
Screw rotation			rpm	50-100

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

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