

IUPILON® POLYCARBONATE

ENGINEERING THERMOPLASTIC

IUPILON® IS A REGISTERED TRADEMARK OF MITSUBISHI ENGINEERING PLASTICS CORPORATION

IUPILON® GS2010R

IUPILON® GS2010R is a 10% glass fibre filled version of Iupilon® S2000 and offers an exceptional combination of product rigidity and strength, heat resistance, dimensional stability, flame retardency, creep resistance and processability with a mould release agent (R) to assist with moulded part ejection. Typical applications of Iupilon® GS2010R include metal substitution such as automotive interior structural brackets, camera frames, industrial electrical switch housings, electrical power tool casings and mounting chassis for electronics devices such as computer printers, laptop computers and VTR units.

	<u>CONDITIONS</u>	<u>UNITS</u>	<u>TYPICAL VALUES</u>	<u>TESTING METHODS</u>
<u>1. Mechanical Properties</u>				
Notched Izod Impact Strength	12.7 x 3.2 mm	J/m	150	ASTM D256
Falling Dart Impact	3.2 mm	J	-	ASTM D3029
Tensile Strength	12.7 x 3.2 mm @ 5.0 mm/min	MPa	71	ASTM D638
Elongation to Fail	12.7 x 3.2 mm @ 5.0 mm/min	%	7	ASTM D638
Flexural Strength	12.7 x 6.4 mm @ 2.8 mm/min	MPa	116	ASTM D790
Flexural Modulus	12.7 x 6.4 mm @ 2.8 mm/min	MPa	3650	ASTM D790
<u>2. Thermal Properties</u>				
Heat Deflection Temperature	12.7 x 6.4 mm @ 1.82 MPa	°C	143	ASTM D648
	12.7 x 6.4 mm @ 0.46 MPa	°C	-	ASTM D648
Coefficient of Linear Thermal Expansion		cm/cm/°C	4.36 exp-5	ASTM D696
<u>3. Electrical Properties</u>				
Dielectric Strength		MV/m	18.4	ASTM D149
Dielectric Constant		MHz	2.88	ASTM D150
<u>4. Physical Properties</u>				
Melt Flow Rate	300°C, 1.20 kg	g/10 min	10 - 12	ASTM D1238
Specific Gravity		-	1.27	ASTM D792
Rockwell Hardness		R	124	ASTM D785
UL Flammability	1.6 mm	Rating	V-2	UL 94
Water Absorption	24 hours	%	0.14	ASTM D570
Total Light Transmittance	3.0 mm	%	-	ASTM D1003
Reinforcement Level		%	10	n/a
Mould Shrinkage	3.0 x Ø100 mm disc	%	0.4±0.2	ASTM D955



TYPICAL PROCESSING CONDITIONS

IUPILON® GS2010R

The following typical guidelines are offered as initial processing conditions for **IUPILON® GS2010R**. In practice, processing parameters may need to be varied to give commercially acceptable performance in conjunction with optimum physical properties. For specific technical advice on part design or processing conditions, contact the Marplex Technical Service Department.

Temperature of pellet bed in dehumidifying drier	120 - 125 °C
Minimum drying time at desired pellet bed temp	4 - 6 hours
Mould temperature	60 - 110 °C
Nozzle temperature	Do not exceed stock temperature
Stock temperature	270 - 300 °C
Cylinder temperatures	Rear 245 - 265 °C
	Middle 260 - 280 °C
	Front 275 - 295 °C
Fill speed	Medium
Screw speed	40 - 60 rpm
Screw back pressure	0.1 - 0.5 MPa
Injection pressure	60 - 140 MPa
Clamp pressure	4 - 8 kN/cm ²

Comment(s):

- 1 Cleanliness of the dryer, machine hopper and machine screw/barrel/nozzle assembly are essential for processing Iupilon® Polycarbonate and producing contamination free moulded components.
- 2 Iupilon® Polycarbonate is not compatible with other polymers.
- 3 It is suggested that the pre-drying, moulding die and material temperatures are manually confirmed using a hand held temperature measuring device.
- 4 Minimise screw back speed during recharge to limit glass fibre breakage.

Conversions: 1 MPa = 145 psi
= 10.2 kg/cm²
= 10 bar
°C = 5(°F-32)/9
1 kN/cm² = 0.65 ton/in²

