

General Information**Product Description**

PC/ABS, Standard grade

General

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|----------|-------------------|
| Features | • General Purpose |
| Uses | • General Purpose |

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	9.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	9.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (24 hr, 23°C)	0.12	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-1/1
Tensile Stress (Yield)	55.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.3	%	
Break	35	%	
Flexural Modulus ²	2600	MPa	ISO 178
Flexural Stress ²	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	34	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	115	°C	ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	7.0E-5	cm/cm/°C	
Transverse	7.0E-5	cm/cm/°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94



Iupilon™ MB2210R
Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

Processing Information		
Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	80 to 100	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	240 to 270	°C
Middle Temperature	240 to 270	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	240 to 270	°C
Mold Temperature	60 to 90	°C

