Mitsubishi Engineering-Plastics Corp.

Iupilon™ MB8300

Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

General Information			
Product Description			
PC/ABS, Flame Retardant (Phosphoric acid), High Flowability, High Heat Resistance			
General			
Additive	• Flame Retardant		
Features	• Flame Retardant	• High Flow	• High Heat Resistance
Uses	• Electrical/Electronic Applications	• General Purpose	• Housings

ASTM & ISO Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.18	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	18	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	17	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.30 to 0.50	%	
Flow	0.30 to 0.50	%	
Water Absorption (24 hr, 23°C)	0.20	%	Internal Method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2800	MPa	ISO 527-1/1
Tensile Stress (Yield)	59.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.0	%	
Break	69	%	
Flexural Modulus [2]	2700	MPa	ISO 178
Flexural Stress [2]	98.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	21	kJ/m²	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	95.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	87.0	°C	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index (CTI)	PLC 0		UL 746A
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.5 mm	V-0		
2.0 mm	5VB		

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Processing Information		
Injection	**Nominal Value**	**Unit**
Drying Temperature - Hot Air Dryer	80	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	230 to 280	°C
Middle Temperature	230 to 280	°C
Front Temperature	230 to 280	°C
Nozzle Temperature	230 to 280	°C
Mold Temperature	50 to 70	°C