

## Iupilon™ MB2222R

Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

| General Information                         |                          |           |                 |
|---------------------------------------------|--------------------------|-----------|-----------------|
| Product Description                         |                          |           |                 |
| PC/ABS, High Impact Strength                |                          |           |                 |
| General                                     |                          |           |                 |
| Features                                    | • High Impact Resistance |           |                 |
| Uses                                        | • General Purpose        |           |                 |
| ASTM & ISO Properties <sup>1</sup>          |                          |           |                 |
| Physical                                    | Nominal Value            | Unit      | Test Method     |
| Density                                     | 1.14                     | g/cm³     | ISO 1183        |
| Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)   | 5.0                      | g/10 min  | ISO 1133        |
| Melt Volume-Flow Rate (MVR) (250°C/2.16 kg) | 5.0                      | cm³/10min | 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                             | 2300                     | MPa       | ISO 527-1/1     |
| Tensile Stress (Yield)                      | 52.0                     | MPa       | ISO 527-2/50    |
| Tensile Strain                              |                          |           | ISO 527-2/50    |
| Yield                                       | 4.8                      | %         |                 |
| Break                                       | 50                       | %         |                 |
| Flexural Modulus <sup>2</sup>               | 2200                     | MPa       | ISO 178         |
| Flexural Stress <sup>2</sup>                | 83.0                     | MPa       | ISO 178         |
| Impact                                      | Nominal Value            | Unit      | Test Method     |
| Charpy Notched Impact Strength (23°C)       | 60                       | 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                        | 128                      | °C        | ISO 75-2/B      |
| 1.8 MPa, Unannealed                         | 107                      | °C        | ISO 75-2/A      |
| CLTE                                        |                          |           | ISO 11359-2     |
| Flow                                        | 7.0E-5                   | cm/cm/°C  |                 |
| Transverse                                  | 7.0E-5                   | cm/cm/°C  |                 |
| Processing Information                      |                          |           |                 |
| Injection                                   | Nominal Value            | Unit      |                 |
| Drying Temperature - Hot Air Dryer          | 100 to 110               | °C        |                 |
| Drying Time - Hot Air Dryer                 | 4.0 to 8.0               | hr        |                 |
| Rear Temperature                            | 240 to 290               | °C        |                 |



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| Injection          | Nominal Value | Unit |
|--------------------|---------------|------|
| Middle Temperature | 240 to 290    | °C   |
| Front Temperature  | 240 to 290    | °C   |
| Nozzle Temperature | 240 to 290    | °C   |
| Mold Temperature   | 60 to 90      | °C   |

