

Iupilon™ MB8500

Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

General Information			
Product Description			
PC/ABS, Flame Retardant (Phosphoric acid), Ultra-High Flowability			
General			
Additive	• Flame Retardant		
Features	• Flame Retardant	• High Flow	
Uses	• Electrical/Electronic Applications • General Purpose		• Housings
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	37	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	36	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.25 to 0.45	%	
Flow	0.25 to 0.45	%	
Water Absorption (24 hr, 23°C)	0.20	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2900	MPa	ISO 527-1/1
Tensile Stress (Yield)	64.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.0	%	
Break	38	%	
Flexural Modulus ²	2800	MPa	ISO 178
Flexural Stress ²	98.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	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	90.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	82.0	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.2 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	220 to 270	°C
Middle Temperature	220 to 270	°C
Front Temperature	220 to 270	°C
Nozzle Temperature	220 to 270	°C
Mold Temperature	50 to 70	°C

