

Iupilon™ MB5002R

Mitsubishi Engineering-Plastics Corp - Polycarbonate + Polyester

General Information			
Product Description			
PC/POLYESTER, persistent anti-static			
General			
Additive	• Antistatic		
Features	• Antistatic		
Uses	• General Purpose		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.0	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.60 to 0.80	%	
Flow	0.60 to 0.80	%	
Water Absorption (24 hr, 23°C)	0.20	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-1/1
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	5.9	%	
Break	140	%	
Flexural Modulus ²	2000	MPa	ISO 178
Flexural Stress ²	78.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	80	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	132	°C	ISO 75-2/B
1.8 MPa, Unannealed	112	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	8.0E-5	cm/cm/°C	
Transverse	9.6E-5	cm/cm/°C	



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Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	7.0E+11	ohms	IEC 60093
Volume Resistivity	3.0E+13	ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
2.00 mm	24	kV/mm	
3.00 mm	18	kV/mm	
Dielectric Constant			IEC 60250
1 MHz	3.50		
100 MHz	4.40		
Dissipation Factor			IEC 60250
1 MHz	0.023		
100 MHz	8.1E-3		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	120	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	270 to 290	°C
Middle Temperature	270 to 290	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	270 to 290	°C
Mold Temperature	60 to 90	°C

