

Iupilon™ MB4306R

Mitsubishi Engineering-Plastics Corp - Polycarbonate + Polyester

General Information			
Product Description			
PC/POLYESTER, Chemical Resistant			
General			
Features	• Chemical Resistant		
Uses	• General Purpose		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	24	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/1
Tensile Stress (Yield)	59.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.8	%	
Break	110	%	
Flexural Modulus ²	2300	MPa	ISO 178
Flexural Stress ²	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	58	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	112	°C	ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.8E-5	cm/cm/°C	
Transverse	6.8E-5	cm/cm/°C	
Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature - Hot Air Dryer	110	°C	
Drying Time - Hot Air Dryer	4.0 to 8.0	hr	
Rear Temperature	270 to 290	°C	



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Injection	Nominal Value	Unit
Middle Temperature	270 to 290	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	270 to 290	°C
Mold Temperature	60 to 90	°C

