

Iupilon® HL-4000

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® HL-4000 is a polycarbonate (PC) material. This product is available in North America, Europe or Asia Pacific region. The processing method is injection molding.

Iupilon® The main features of the HL-4000 are:

flame retardant/rated flame

high liquidity

General Information			
UL YellowCard	E41179-231925		
Features	High liquidity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	63	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	60.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Vertical flow direction: 3.20mm	0.40 - 0.60	%	
Flow direction: 3.20mm	0.40 - 0.60	%	
Water Absorption (Saturation, 23°C)	0.24	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2
Tensile Stress (Yield)	62.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.7	%	ISO 527-2
Nominal Tensile Strain at Break	96	%	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	40	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	136	°C	ISO 75-2/B
1.8 MPa, not annealed	123	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	ISO 11359-2
Lateral	6.6E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Dielectric Strength			IEC 60243-1
1.00 mm	31	kV/mm	IEC 60243-1
3.00 mm	18	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.10		IEC 60250
1 MHz	3.10		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	6.0E-4		IEC 60250
1 MHz	9.0E-3		IEC 60250
Comparative Tracking Index (CTI)	PLC 2		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.380 mm)	V-2		UL 94

Additional Information

HL-4002 : YI Stabilized

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 - 8.0	hr
Rear Temperature	260 - 320	°C
Middle Temperature	270 - 330	°C
Front Temperature	280 - 340	°C
Nozzle Temperature	280 - 340	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	50.0 - 150	MPa
Screw Speed	50 - 150	rpm

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