

Iupilon® GSH2050DF

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® GSH2050DF is a Polycarbonate (PC) material filled with 50% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® GSH2050DF are:

Flame Rated

Warp Resistant

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Features	Low Warpage		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	2.2	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	1.70	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.10 to 0.30	%	
Flow : 3.20 mm	0.10 to 0.30	%	
Water Absorption (Saturation, 23°C)	0.070	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11600	MPa	ISO 527-2
Tensile Stress (Break)	102	MPa	ISO 527-2
Tensile Strain (Break)	1.4	%	ISO 527-2
Flexural Modulus	10800	MPa	ISO 178
Flexural Stress	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	31	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	144	°C	ISO 75-2/B
1.8 MPa, Unannealed	138	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	1.8E-5	cm/cm/°C	
Transverse	3.9E-5	cm/cm/°C	
Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI)	PLC 4		UL 746

Flammability	Nominal Value	Test Method
Flame Rating (0.400 mm)	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	270 to 290	°C
Middle Temperature	280 to 300	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	290 to 310	°C
Mold Temperature	80.0 to 120	°C
Injection Pressure	50.0 to 150	MPa
Screw Speed	50 to 100	rpm

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