

Iupilon® ELV2020

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Wear Resistance Improved

General Information			
UL YellowCard	E41179-100949963		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm ³	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)	9.30	cm ³ /10min	ISO 1133
Molding Shrinkage			
Lateral flow: 3.20mm	0.50 - 0.70	%	
Traffic: 3.20mm	0.50 - 0.70	%	
Water Absorption (Saturation, 23°C)	0.12	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2
Tensile Stress (Yield)	53.0	MPa	ISO 527-2
Tensile Strain (Yield)	6.6	%	ISO 527-2
Nominal Tensile Strain at Break	100	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	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	142	°C	ISO 75-2/B
1.8 MPa, not annealed	126	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	6.6E-5	cm/cm/°C	ISO 11359-2
Lateral	7.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Test Method	
Comparative Tracking Index (CTI)	PLC 4	UL 746	
Flammability	Nominal Value	Test Method	
Flame Rating (0.8 mm)	V-2	UL 94	

Injection	Nominal Value	Unit
Rear Temperature	270 - 290	°C
Middle Temperature	280 - 300	°C
Front Temperature	280 - 300	°C
Nozzle Temperature	280 - 300	°C
Mold Temperature	70 - 100	°C
Injection Pressure	50.0 - 150	MPa
Screw Speed	50 - 100	rpm

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