

# Iupilon® MB6001UR

Polycarbonate + Acrylic (PMMA)

Mitsubishi Engineering-Plastics Corp

## Message:

Iupilon® MB6001UR is a Polycarbonate + Acrylic (PMMA) (PC+Acrylic) material. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of Iupilon® MB6001UR: Wear Resistant.

| General Information                        |                          |                        |             |
|--------------------------------------------|--------------------------|------------------------|-------------|
| Features                                   | Good Abrasion Resistance |                        |             |
| Appearance                                 | Clear/Transparent        |                        |             |
| Forms                                      | Pellets                  |                        |             |
| Processing Method                          | Injection Molding        |                        |             |
| Physical                                   | Nominal Value            | Unit                   | Test Method |
| Density                                    | 1.19                     | g/cm <sup>3</sup>      | ISO 1183    |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)   | 49                       | g/10 min               | ISO 1133    |
| Melt Volume-Flow Rate (MVR) (300°C/1.2 kg) | 47.0                     | cm <sup>3</sup> /10min | ISO 1133    |
| Molding Shrinkage                          |                          |                        |             |
| Across Flow : 3.20 mm                      | 0.40 to 0.60             | %                      |             |
| Flow : 3.20 mm                             | 0.40 to 0.60             | %                      |             |
| Water Absorption (Saturation, 23°C)        | 0.20                     | %                      |             |
| Mechanical                                 | Nominal Value            | Unit                   | Test Method |
| Tensile Modulus                            | 2700                     | MPa                    | ISO 527-2   |
| Tensile Stress (Yield)                     | 75.0                     | MPa                    | ISO 527-2   |
| Tensile Strain (Yield)                     | 5.8                      | %                      | ISO 527-2   |
| Nominal Tensile Strain at Break            | 60                       | %                      | ISO 527-2   |
| Flexural Modulus                           | 2800                     | MPa                    | ISO 178     |
| Flexural Stress                            | 113                      | MPa                    | ISO 178     |
| Impact                                     | Nominal Value            | Unit                   | Test Method |
| Charpy Notched Impact Strength (23°C)      | 2.0                      | kJ/m <sup>2</sup>      | ISO 179     |
| Charpy Unnotched Impact Strength (23°C)    | 100                      | kJ/m <sup>2</sup>      | ISO 179     |
| Thermal                                    | Nominal Value            | Unit                   | Test Method |
| Heat Deflection Temperature                |                          |                        |             |
| 0.45 MPa, Unannealed                       | 117                      | °C                     | ISO 75-2/B  |
| 1.8 MPa, Unannealed                        | 104                      | °C                     | ISO 75-2/A  |
| CLTE                                       |                          |                        | ISO 11359-2 |
| Flow                                       | 6.1E-5                   | cm/cm/°C               |             |
| Transverse                                 | 6.5E-5                   | cm/cm/°C               |             |
| Injection                                  | Nominal Value            | Unit                   |             |
| Drying Temperature                         | 100                      | °C                     |             |
| Drying Time                                | 4.0 to 8.0               | hr                     |             |

|                    |              |     |
|--------------------|--------------|-----|
| Rear Temperature   | 250 to 270   | °C  |
| Middle Temperature | 260 to 280   | °C  |
| Front Temperature  | 270 to 285   | °C  |
| Nozzle Temperature | 270 to 285   | °C  |
| Mold Temperature   | 60.0 to 95.0 | °C  |
| Injection Pressure | 50.0 to 100  | MPa |
| Screw Speed        | 50 to 100    | rpm |

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