

Iupilon® GPN2050DF

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® GPN2050DF 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® GPN2050DF are:

Flame Rated

Flame Retardant

High Flow

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	High Flow		
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)	4.3	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	2.90	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.050 to 0.20	%	
Flow : 3.20 mm	0.050 to 0.20	%	
Water Absorption (Saturation, 23°C)	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13200	MPa	ISO 527-2
Tensile Stress (Break)	91.0	MPa	ISO 527-2
Tensile Strain (Break)	1.1	%	ISO 527-2
Flexural Modulus	12800	MPa	ISO 178
Flexural Stress	165	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	29	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	120	°C	ISO 75-2/B
1.8 MPa, Unannealed	115	°C	ISO 75-2/A
CLTE			ISO 11359-2

Flow	1.9E-5	cm/cm/°C
Transverse	2.6E-5	cm/cm/°C
Flammability	Nominal Value	Test Method
Flame Rating (1.60 mm)	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	260 to 290	°C
Middle Temperature	270 to 300	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 300	°C
Mold Temperature	60.0 to 100	°C
Injection Pressure	50.0 to 150	MPa
Screw Speed	50 to 100	rpm

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

