

# Iupilon® MB1800

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

## Message:

Iupilon® MB1800 is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of Iupilon® MB1800: Flame Rated.

General Information			
UL YellowCard	E41179-231980		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	14	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	14.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.30 to 0.50	%	
Flow : 3.20 mm	0.30 to 0.50	%	
Water Absorption (Saturation, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2
Tensile Stress (Yield)	60.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	%	ISO 527-2
Nominal Tensile Strain at Break	92	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	40	kJ/m <sup>2</sup>	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	89.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	81.0	°C	ISO 75-2/A
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.20 mm	V-0		
2.00 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	4.0 to 8.0	hr
Rear Temperature	210 to 250	°C
Middle Temperature	220 to 260	°C
Front Temperature	230 to 270	°C
Nozzle Temperature	230 to 270	°C
Mold Temperature	50.0 to 70.0	°C
Injection Pressure	50.0 to 150	MPa
Screw Speed	30 to 50	rpm

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#### Recommended distributors for this material

### 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

