

Iupilon® ML-400

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® ML-400 is a Polycarbonate (PC) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® ML-400 are:

High Flow

High Viscosity

Typical application of Iupilon® ML-400: Automotive

General Information			
Features	High Flow		
	High Viscosity		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	31	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	30.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.50 to 0.70	%	
Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.24	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2
Tensile Stress (Yield)	64.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.9	%	ISO 527-2
Nominal Tensile Strain at Break	80	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	99.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	50	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, Unannealed	135	°C	ISO 75-2/B
1.8 MPa, Unannealed	123	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.3E-5	cm/cm/°C	
Transverse	7.3E-5	cm/cm/°C	

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	4.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
1.00 mm	31	kV/mm	
3.00 mm	17	kV/mm	
Relative Permittivity			IEC 60250
100 Hz	3.10		
1 MHz	3.10		
Dissipation Factor			IEC 60250
100 Hz	7.0E-4		
1 MHz	9.0E-3		
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	260 to 280	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	280 to 300	°C	
Nozzle Temperature	280 to 300	°C	
Mold Temperature	70.0 to 100	°C	
Injection Pressure	50.0 to 150	MPa	
Screw Speed	50 to 100	rpm	

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