

Iupilon® DH3002R

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® DH3002R is a Polycarbonate (PC) material. It is available in Asia Pacific, Europe, or North America for injection molding.

General Information			
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)	30	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	28.0	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	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Yield)	62.0	MPa	ISO 527-2
Tensile Strain (Yield)	6.6	%	ISO 527-2
Nominal Tensile Strain at Break	110	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	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	136	°C	ISO 75-2/B
1.8 MPa, Unannealed	122	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	
Transverse	6.6E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms · cm	IEC 60093
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	270 to 300	°C
Nozzle Temperature	270 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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Recommended distributors for this material

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