

# Iupilon® MB8700

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

## Message:

Iupilon® MB8700 is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® MB8700 are:

Flame Rated

High Flow

General Information			
UL YellowCard	E41179-347152		
Features	High Flow		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	35	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	35.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.25 to 0.45	%	
Flow : 3.20 mm	0.25 to 0.45	%	
Water Absorption (Saturation, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ISO 527-2
Tensile Stress (Yield)	63.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.5	%	ISO 527-2
Nominal Tensile Strain at Break	16	%	ISO 527-2
Flexural Modulus	3100	MPa	ISO 178
Flexural Stress	99.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	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
1.00 mm	V-0		
1.20 mm	5VB		

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	200 to 250	°C
Middle Temperature	210 to 260	°C
Front Temperature	220 to 270	°C
Nozzle Temperature	220 to 270	°C
Mold Temperature	50.0 to 70.0	°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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