

Iupilon® MB1700

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® MB1700 is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® MB1700 are:

Flame Rated

Flame Retardant

General Information			
UL YellowCard	E41179-231979		
Additive	Flame Retardant		
Features	Flame Retardant		
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) (260°C/2.16 kg)	14	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	14.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.20 to 0.40	%	
Flow : 3.20 mm	0.20 to 0.40	%	
Water Absorption (Saturation, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2
Tensile Stress (Yield)	61.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.9	%	ISO 527-2
Nominal Tensile Strain at Break	55	%	ISO 527-2
Flexural Modulus	3000	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	20	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	92.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	82.0	°C	ISO 75-2/A
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.400 mm	HB		

0.600 mm	V-2	
0.810 mm	V-0	
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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