

Iupilon® TMB1615

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® TMB1615 is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® TMB1615 are:

Flame Rated

High Stiffness

General Information			
UL YellowCard	E41179-231984		
Features	High Stiffness		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	11	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	11.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.15 to 0.35	%	
Flow : 3.20 mm	0.15 to 0.35	%	
Water Absorption (Saturation, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4600	MPa	ISO 527-2
Tensile Stress (Yield)	67.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.8	%	ISO 527-2
Nominal Tensile Strain at Break	8.0	%	ISO 527-2
Flexural Modulus	4600	MPa	ISO 178
Flexural Stress	108	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	150	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	100	°C	ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating (1.00 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	3.0 to 5.0	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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