

Iupilon® CGH1020KR

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® CGH1020KR is a Polycarbonate (PC) material filled with 10% carbon fiber and 20% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® CGH1020KR are:

Flame Rated

High Flow

General Information			
Filler / Reinforcement	Carbon Fiber,10% Filler by Weight		
	Glass Fiber,20% Filler by Weight		
Features	High Flow		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.2	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	4.60	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.20 to 0.40	%	
Flow : 3.20 mm	0.050 to 0.20	%	
Water Absorption (Saturation, 23°C)	0.090	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13000	MPa	ISO 527-2
Tensile Stress (Break)	127	MPa	ISO 527-2
Tensile Strain (Break)	1.7	%	ISO 527-2
Flexural Modulus	12500	MPa	ISO 178
Flexural Stress	195	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	145	°C	ISO 75-2/B
1.8 MPa, Unannealed	141	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	1.3E-5	cm/cm/°C	
Transverse	5.4E-5	cm/cm/°C	

Flammability	Nominal Value	Test Method
Flame Rating (0.400 mm)	HB	UL 94

Injection	Nominal Value	Unit
Rear Temperature	270 to 290	°C
Middle Temperature	280 to 300	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	290 to 310	°C
Mold Temperature	80.0 to 120	°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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