

Iupilon® GS2020MN1

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® GS2020MN1 is a Polycarbonate (PC) material filled with 20% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® GS2020MN1 are:

Flame Rated

Flame Retardant

General Information			
UL YellowCard	E41179-231889		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.30 to 0.50	%	
Flow : 3.20 mm	0.10 to 0.30	%	
Water Absorption (Saturation, 23°C)	0.11	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6500	MPa	ISO 527-2
Tensile Stress (Break)	97.0	MPa	ISO 527-2
Tensile Strain (Break)	2.7	%	ISO 527-2
Flexural Modulus	5900	MPa	ISO 178
Flexural Stress	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	50	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	146	°C	ISO 75-2/B
1.8 MPa, Unannealed	143	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	2.7E-5	cm/cm/°C	
Transverse	6.2E-5	cm/cm/°C	

Electrical	Nominal Value	Test Method
Comparative Tracking Index (CTI)	PLC 4	UL 746
Flammability	Nominal Value	Test Method
Flame Rating (0.750 mm)	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 to 8.0	hr
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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