

Iupilon® HL-3503

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Light guide Grade (For Automobile)

High flow

Heat Resistant

High luminance

General Information			
Features	High liquidity		
	Heat resistance, medium		
Uses	Application in Automobile Field		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	56	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	53.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Lateral flow: 3.20mm	0.40 - 0.60	%	
Traffic: 3.20mm	0.40 - 0.60	%	
Water Absorption (Saturation, 23°C)	0.24	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Yield)	63.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.6	%	ISO 527-2
Nominal Tensile Strain at Break	87	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	99.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	49	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, not annealed	135	°C	ISO 75-2/B
1.8 MPa, not annealed	122	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	ISO 11359-2

Lateral	6.6E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Dielectric Strength			IEC 60243-1
1.00 mm	31	kV/mm	IEC 60243-1
3.00 mm	18	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.10		IEC 60250
1 MHz	3.10		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	6.0E-4		IEC 60250
1 MHz	9.0E-3		IEC 60250
Comparative Tracking Index (CTI)	PLC 2		UL 746
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 - 8.0	hr	
Rear Temperature	260 - 270	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	270 - 290	°C	
Nozzle Temperature	270 - 290	°C	
Mold Temperature	80 - 120	°C	
Injection Pressure	50.0 - 150	MPa	
Screw Speed	50 - 150	rpm	

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