

Iupilon® MB2213R

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® MB2213R is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® MB2213R are:

Flame Rated

Heat Resistant

Typical application of Iupilon® MB2213R: Automotive

General Information			
UL YellowCard	E41179-231713		
Features	High Heat Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	10	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.40 to 0.60	%	
Flow : 3.20 mm	0.40 to 0.60	%	
Water Absorption (Saturation, 23°C)	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2
Tensile Stress (Yield)	59.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.9	%	ISO 527-2
Nominal Tensile Strain at Break	76	%	ISO 527-2
Flexural Modulus	2400	MPa	ISO 178
Flexural Stress	94.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	50	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	130	°C	ISO 75-2/B
1.8 MPa, Unannealed	110	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	7.0E-5	cm/cm/°C	
Transverse	7.0E-5	cm/cm/°C	

Flammability	Nominal Value	Test Method
Flame Rating (1.00 mm)	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0 to 110	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	220 to 270	°C
Middle Temperature	230 to 280	°C
Front Temperature	240 to 290	°C
Nozzle Temperature	240 to 290	°C
Mold Temperature	60.0 to 90.0	°C
Injection Pressure	50.0 to 150	MPa
Screw Speed	50 to 100	rpm

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