

Iupilon® CLS400

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® CLS400 is a Polycarbonate (PC) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® CLS400 are:

High Viscosity

UV Stabilized

Typical applications include:

Medical/Healthcare

Optics/Lenses

General Information			
Additive	UV Stabilizer		
Features	High Viscosity		
Uses	Eyeglasses		
	Lenses		
Forms	Pellets		
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)	8.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	7.50	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.50 to 0.70	%	
Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.24	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Yield)	60.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.5	%	ISO 527-2
Nominal Tensile Strain at Break	110	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	84	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	145	°C	ISO 75-2/B

1.8 MPa, Unannealed	131	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	
Transverse	6.6E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	6.0E+15	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
1.00 mm	31	kV/mm	
3.00 mm	18	kV/mm	
Relative Permittivity			IEC 60250
100 Hz	3.10		
1 MHz	3.10		
Dissipation Factor			IEC 60250
100 Hz	6.0E-4		
1 MHz	9.0E-3		
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	260 to 280	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	270 to 300	°C	
Nozzle Temperature	270 to 300	°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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