

Iupilon® MB9000

Polycarbonate + ABS

Mitsubishi Engineering-Plastics Corp

Message:

Polymer Alloy (PC/ABS)-2

Phosphoric acid

High Flowability

Good Surface

High Impact

General Information			
UL YellowCard	E41179-101563193		
Features	Impact resistance, high		
	High liquidity		
	Excellent appearance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	27	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	25.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Lateral flow: 3.20mm	0.25 - 0.45	%	
Traffic: 3.20mm	0.25 - 0.45	%	
Water Absorption (Saturation, 23°C)	0.20	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2
Tensile Stress (Yield)	60.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.5	%	ISO 527-2
Nominal Tensile Strain at Break	63	%	ISO 527-2
Flexural Modulus	2700	MPa	ISO 178
Flexural Stress	94.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	24	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	86.0	°C	ISO 75-2/B
1.8 MPa, not annealed	78.0	°C	ISO 75-2/A

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.0 mm	V-1	UL 94
1.5 mm	5VB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	4.0 - 8.0	hr
Rear Temperature	200 - 240	°C
Middle Temperature	210 - 250	°C
Front Temperature	220 - 270	°C
Nozzle Temperature	220 - 270	°C
Mold Temperature	50 - 70	°C
Injection Pressure	50.0 - 150	MPa
Screw Speed	50 - 100	rpm

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