

Iupilon® GPN2030DF

Polycarbonate

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® GPN2030DF is a Polycarbonate (PC) material filled with 30% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® GPN2030DF are:

Flame Rated

Flame Retardant

High Flow

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	High Flow		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.4	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	7.40	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow : 3.20 mm	0.050 to 0.25	%	
Flow : 3.20 mm	0.050 to 0.25	%	
Water Absorption (Saturation, 23°C)	0.090	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7500	MPa	ISO 527-2
Tensile Stress (Break)	72.0	MPa	ISO 527-2
Tensile Strain (Break)	1.9	%	ISO 527-2
Flexural Modulus	7700	MPa	ISO 178
Flexural Stress	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	23	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	124	°C	ISO 75-2/B
1.8 MPa, Unannealed	118	°C	ISO 75-2/A
CLTE			ISO 11359-2

Flow	2.7E-5	cm/cm/°C
Transverse	3.3E-5	cm/cm/°C
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.60 mm	V-0	
3.00 mm	5VA	
Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	260 to 290	°C
Middle Temperature	270 to 300	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 300	°C
Mold Temperature	60.0 to 100	°C
Injection Pressure	50.0 to 150	MPa
Screw Speed	50 to 100	rpm

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