

Iupilon® MB4306R

Polycarbonate + Polyester

Mitsubishi Engineering-Plastics Corp

Message:

Iupilon® MB4306R is a Polycarbonate + Polyester (PC+Polyester) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Iupilon® MB4306R are:

Chemical Resistant

Weldable

General Information			
Features	Good Chemical Resistance		
	Weldable		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	24.0	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)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Yield)	59.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.8	%	ISO 527-2
Nominal Tensile Strain at Break	110	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	58	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	112	°C	ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.8E-5	cm/cm/°C	
Transverse	6.8E-5	cm/cm/°C	

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	250 to 270	°C
Middle Temperature	260 to 280	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	270 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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Recommended distributors for this material

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