

## Iupilon™ E-2000

Mitsubishi Engineering-Plastics Corp - Polycarbonate

### General Information

#### Product Description

Extrusion

#### General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Features	• High Viscosity
Uses	• General Purpose
Processing Method	• Extrusion

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	5.3	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	5.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (24 hr, 73°F)	0.24	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	348000	psi	ISO 527-1/1
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Tensile Strain (Yield)	5.4	%	ISO 527-2/50
Tensile Strain (Break)	110	%	ISO 527-2/50
Flexural Modulus <sup>2</sup>	334000	psi	ISO 178
Flexural Stress <sup>2</sup>	13500	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	42	ft·lb/in <sup>2</sup>	ISO 179
Charpy Unnotched Impact Strength (73°F)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	293	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	268	°F	ISO 75-2/A
CLTE - Flow	3.6E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	3.7E-5	in/in/°F	ISO 11359-2
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
0.0394 in	790	V/mil	
0.118 in	460	V/mil	
Dielectric Constant			IEC 60250
1 MHz	3.10		
100 MHz	3.10		
Dissipation Factor			IEC 60250
1 MHz	9.0E-3		
100 MHz	6.0E-4		
Comparative Tracking Index (CTI)	PLC 2		UL 746A

### Processing Information

#### Injection

#### Nominal Value Unit



Drying Temperature - Hot Air Dryer	248 °F
Drying Time - Hot Air Dryer	4.0 to 8.0 hr
Rear Temperature	536 to 590 °F
Middle Temperature	536 to 590 °F
Front Temperature	536 to 590 °F
Nozzle Temperature	536 to 590 °F
Mold Temperature	176 to 230 °F

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 0.079 in/min

