Iupilon™ E-2000R

Mitsubishi Engineering-Plastics Corp - *Polycarbonate*

General Information

Product Description			
Extrusion, Mold release improved			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Mold Release	• High Viscosity	
Uses	• General Purpose		
Processing Method	• Extrusion		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm³	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	cm³/10min	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 [2]	334000	psi	ISO 178
Flexural Stress [2]	13500	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	42	ft·lb/in²	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

[1] Typical properties: these are not to be construed as specifications.

[2] 0.079 in/min