

Mitsubishi Iupilon® H2001R 23 MFI FDA Compliant Polycarbonate With Release

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Unreinforced, Flame Retardant

Material Notes:

Information provided by US distributor Polymer Technology and Services, LLC (PTS).

Order this product through the following link:

http://www.lookpolymers.com/polymer_Mitsubishi-Iupilon-H2001R-23-MFI-FDA-Compliant-Polycarbonate-With-Release.php

Physical Properties	Metric	English	Comments
Density	1.20 g/cc	0.0434 lb/in ³	ASTM D792
Water Absorption	0.25 %	0.25 %	24 hours at 73°F
Linear Mold Shrinkage	0.0050 - 0.0080 cm/cm	0.0050 - 0.0080 in/in	ASTM D955
Melt Flow	23 g/10 min @Load 1.20 kg, Temperature 300 °C	23 g/10 min @Load 2.65 lb, Temperature 572 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell M	65	65	ASTM D785
Hardness, Rockwell R	122	122	ASTM D785
Tensile Strength, Ultimate	63.6 MPa @Thickness 3.17 mm	9220 psi @Thickness 0.125 in	
Tensile Strength, Yield	60.3 MPa @Thickness 3.17 mm	8750 psi @Thickness 0.125 in	
Elongation at Break	120 % @Thickness 3.17 mm	120 % @Thickness 0.125 in	
Flexural Yield Strength	85.1 MPa @Thickness 3.17 mm	12300 psi @Thickness 0.125 in	
Flexural Modulus	2.25 GPa @Thickness 3.17 mm	326 ksi @Thickness 0.125 in	
Izod Impact, Notched	6.94 J/cm @Thickness 3.17 mm	13.0 ft-lb/in @Thickness 0.125 in	

Thermal Properties	Metric	English	Comments
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Thermal Properties	Metric	English	Comments
CTE, linear	117 $\mu\text{m/m}\cdot\text{Å}^\circ\text{C}$	65.9 $\mu\text{in/in}\cdot\text{Å}^\circ\text{F}$	ASTM D696
	@Temperature 20.0 $\text{Å}^\circ\text{C}$	@Temperature 68.0 $\text{Å}^\circ\text{F}$	
Deflection Temperature at 1.8 MPa (264 psi)	128 $\text{Å}^\circ\text{C}$	262 $\text{Å}^\circ\text{F}$	ASTM D648
Flammability, UL94	V-2	V-2	
	@Thickness 1.59 mm	@Thickness 0.0625 in	

Optical Properties	Metric	English	Comments
Refractive Index	1.585	1.585	nD
Transmission, Visible	87 %	87 %	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	243 - 260 $\text{Å}^\circ\text{C}$	470 - 500 $\text{Å}^\circ\text{F}$	
Middle Barrel Temperature	249 - 260 $\text{Å}^\circ\text{C}$	480 - 500 $\text{Å}^\circ\text{F}$	
Front Barrel Temperature	260 - 271 $\text{Å}^\circ\text{C}$	500 - 520 $\text{Å}^\circ\text{F}$	
Nozzle Temperature	254 - 271 $\text{Å}^\circ\text{C}$	490 - 520 $\text{Å}^\circ\text{F}$	
Melt Temperature	260 - 282 $\text{Å}^\circ\text{C}$	500 - 540 $\text{Å}^\circ\text{F}$	
Mold Temperature	71.1 - 93.3 $\text{Å}^\circ\text{C}$	160 - 200 $\text{Å}^\circ\text{F}$	
Drying Temperature	121 $\text{Å}^\circ\text{C}$	250 $\text{Å}^\circ\text{F}$	
Dry Time	3 - 4 hour	3 - 4 hour	48 hours max.
Injection Pressure	51.7 - 124 MPa	7500 - 18000 psi	
Back Pressure	0.345 - 1.38 MPa	50.0 - 200 psi	
Clamp Pressure	27.6 - 68.9 MPa	4000 - 10000 psi	
Shot Size	40 - 60 %	40 - 60 %	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

Descriptive Properties	Value	Comments
Injection Speed- Edge Gate	Slow to Medium	
Injection Speed- Tab Gate	Medium to Fast	
Injection Speed- Tunnel Gate	Fast	

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