

## Mitsubishi Iupilon® S2000R 9.5 MFI 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-S2000R-95-MFI-Polycarbonate-With-Release.php](http://www.lookpolymers.com/polymer_Mitsubishi-Iupilon-S2000R-95-MFI-Polycarbonate-With-Release.php)

Physical Properties	Metric	English	Comments
Density	1.20 g/cc	0.0434 lb/in <sup>3</sup>	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	9.5 g/10 min @Load 1.20 kg, Temperature 300 °C	9.5 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	123	123	ASTM D785
Tensile Strength, Ultimate	66.5 MPa @Thickness 3.17 mm	9650 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	87.1 MPa @Thickness 3.17 mm	12600 psi @Thickness 0.125 in	
Flexural Modulus	2.25 GPa @Thickness 3.17 mm	326 ksi @Thickness 0.125 in	
Izod Impact, Notched	9.45 J/cm @Thickness 3.17 mm	17.7 ft-lb/in @Thickness 0.125 in	

Thermal Properties	Metric	English	Comments
	117 µm/m-°C	65.0 µin/in-°F	

CTE linear Thermal Properties	Metric @ Temperature 20.0 Â°C	English @ Temperature 68.0 Â°F	ASTM D696 Comments
Deflection Temperature at 0.46 MPa (66 psi)	140 Â°C	284 Â°F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	128 Â°C	262 Â°F	ASTM D648
Flammability, UL94	V-2 @Thickness 1.59 mm	V-2 @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	266 - 277 Â°C	510 - 530 Â°F	
Middle Barrel Temperature	271 - 282 Â°C	520 - 540 Â°F	
Front Barrel Temperature	282 - 299 Â°C	540 - 570 Â°F	
Nozzle Temperature	277 - 304 Â°C	530 - 580 Â°F	
Melt Temperature	288 - 316 Â°C	550 - 600 Â°F	
Mold Temperature	71.1 - 93.3 Â°C	160 - 200 Â°F	
Drying Temperature	121 Â°C	250 Â°F	
Dry Time	3 - 4 hour	3 - 4 hour	48 hours max.
Injection Pressure	82.7 - 124 MPa	12000 - 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	

Descriptive Properties	Value	Comments
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## Contact Songhan Plastic Technology Co.,Ltd.

Website : [www.lookpolymers.com](http://www.lookpolymers.com)

Email : [sales@lookpolymers.com](mailto:sales@lookpolymers.com)

Tel : +86 021-51131842

Mobile : +86 13061808058

Skype : lookpolymers

Address : United North Road 215,Fengxian District, Shanghai City,China