Iupilon™ GSH2020KR

Mitsubishi Engineering-Plastics Corp - *Polycarbonate*

General Information

Product Description			
Glass Fiber Reinforced (High Flow), GF20%			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• High Flow		
Uses	• General Purpose		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.7	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	8.3	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.30 to 0.50	%	
Flow	0.10 to 0.30	%	
Water Absorption (Saturation, 73°F)	0.11	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	885000	psi	ISO 527-1/1
Tensile Stress (Break)	13800	psi	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
Flexural Modulus [2]	812000	psi	ISO 178
Flexural Stress [2]	22200	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	4.3	ft·lb/in²	ISO 179
Charpy Unnotched Impact Strength (73°F)	24	ft·lb/in²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	291	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	284	°F	ISO 75-2/A
CLTE - Flow	1.5E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	3.4E-5	in/in/°F	ISO 11359-2
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index (CTI)	PLC 3		UL 746A
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.016 in)	HB		UL 94

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	554 to 590	°F
Middle Temperature	554 to 590	°F
Front Temperature	554 to 590	°F
Nozzle Temperature	554 to 590	°F
Mold Temperature	176 to 248	°F

Notes

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

[2] 0.079 in/min