

LUCEL HI510

(POM+TPU)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	14	g/10min	ASTM D 1238
Temperature	190	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.0185	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	54	MPa	ASTM D 638
Elongation at Break	90	%	ASTM D 638
Flexural Modulus	1864	MPa	ASTM D 790
Flexural Strength	64.7	MPa	ASTM D 790
Rockwell Hardness	R 70	-	ASTM D 785
Izod Impact notched, 1/4 in	113	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.98	mm	-
DTUL @ 66 psi	150	°C	ASTM D 648
DTUL @ 264 psi	95	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Surface Resistivity	1E13	Ohm	ASTM D 257
Volume Resistivity	1E15	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Density	1380	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.1	%	-
Melt temperature	200 - 220	°C	-
Mold temperature	80 - 110	°C	-
Zone 1	160 - 180	°C	-
Zone 2	170 - 190	°C	-
Zone 3	180 - 200	°C	-
Nozzle temperature	180 - 200	°C	-
Screw speed	80 - 110	rpm	-
Back pressure	0.5 - 3	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified

Applications

Automotive

Regional Availability

North America, Europe, Asia Pacific, South and Central America