

LUCEL HI515W

(POM+TPE)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	9	g/10min	ASTM D 1238
Temperature	190	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.0185	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength at Yield	41.9	MPa	ASTM D 638
Elongation at Break	67	%	ASTM D 638
Flexural Modulus	1419	MPa	ASTM D 790
Flexural Strength	47.3	MPa	ASTM D 790
Rockwell Hardness	R 64	-	ASTM D 785
Izod Impact notched, 1/4 in	69.7	J/m	ASTM D 256
Thermal properties			
ASTM Data			
DTUL @ 264 psi	79	°C	ASTM D 648
Other properties			
Density	1330	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80 - 110	°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