

**LUCEL HI525L**

(POM+TPE)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
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
<b>Mechanical properties</b>			
<b>ASTM Data</b>			
Tensile Strength at Yield	36.2	MPa	ASTM D 638
Elongation at Break	85	%	ASTM D 638
Flexural Modulus	1195	MPa	ASTM D 790
Flexural Strength	40.4	MPa	ASTM D 790
Rockwell Hardness	R 64	-	ASTM D 785
Izod Impact notched, 1/4 in	76.3	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ASTM Data</b>			
DTUL @ 264 psi	74	°C	ASTM D 648
<b>Other properties</b>			
Density	1310	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
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

**Regional Availability**

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

**Special Characteristics**

High impact or impact modified