

LEMALLOY BX505

(PPE+PA6)

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	14 / *	cm ³ /10min	ISO 1133
Temperature	280 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	1.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	2200 / 1200	MPa	ISO 527
Yield stress	54 / 38	MPa	ISO 527
Yield strain	4.2 / 19	%	ISO 527
Strain at break	41 / 120	%	ISO 527
Flexural modulus, 23°C	2000 / 1200	MPa	ISO 178
Flexural strength	80 / 47	MPa	ISO 178
Charpy notched impact strength, +23°C	22 / 88	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	70 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	155 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	90 / *	E-6/K	ISO 11359-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1090 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110 - 120	°C	-
Pre-drying - Time	2 - 4	h	-
Mold temperature	60 - 100	°C	-
Zone 1	240 - 270	°C	-
Zone 2	250 - 290	°C	-
Zone 3	250 - 290	°C	-
Nozzle temperature	250 - 290	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa