

**LEMALLOY BX528A-3**

(PPE+PA6)

Mitsubishi Engineering-Plastics Corporation

| <b>Processing/Physical Characteristics</b> | <b>dry / cond</b> | <b>Unit</b>            | <b>Test Standard</b> |
|--|-------------------|------------------------|----------------------|
| <b>ISO Data</b>                            |                   |                        |                      |
| Melt volume-flow rate, MVR                 | 15 / *            | cm <sup>3</sup> /10min | ISO 1133             |
| Temperature                                | 280 / *           | °C                     | -                    |
| Load                                       | 5 / *             | kg                     | -                    |
| Molding shrinkage, parallel                | 1.3 / *           | %                      | ISO 294-4, 2577      |
| Molding shrinkage, normal                  | 1.1 / *           | %                      | ISO 294-4, 2577      |

| <b>Mechanical properties</b>          | <b>dry / cond</b> | <b>Unit</b>       | <b>Test Standard</b> |
|---------------------------------------|-------------------|-------------------|----------------------|
| <b>ISO Data</b>                       |                   |                   |                      |
| Tensile Modulus                       | 2500 / 1400       | MPa               | ISO 527              |
| Yield stress                          | 62 / 37           | MPa               | ISO 527              |
| Yield strain                          | 5 / 15            | %                 | ISO 527              |
| Strain at break                       | 57 / 140          | %                 | ISO 527              |
| Flexural modulus, 23°C                | 2300 / 1400       | MPa               | ISO 178              |
| Flexural strength                     | 91 / 60           | MPa               | ISO 178              |
| Charpy notched impact strength, +23°C | 26 / 66           | kJ/m <sup>2</sup> | ISO 179/1eA          |

| <b>Thermal properties</b>                   | <b>dry / cond</b> | <b>Unit</b> | <b>Test Standard</b> |
|---|-------------------|-------------|----------------------|
| <b>ISO Data</b>                             |                   |             |                      |
| Temp. of deflection under load, 1.80 MPa    | 85 / *            | °C          | ISO 75-1/-2          |
| Temp. of deflection under load, 0.45 MPa    | 170 / *           | °C          | ISO 75-1/-2          |
| Coeff. of linear therm. expansion, parallel | 90 / *            | E-6/K       | ISO 11359-1/-2       |

| <b>Other properties</b> | <b>dry / cond</b> | <b>Unit</b>       | <b>Test Standard</b> |
|-------------------------|-------------------|-------------------|----------------------|
| Density                 | 1150 / -          | kg/m <sup>3</sup> | ISO 1183             |

| <b>Processing Recommendation Injection Molding</b> | <b>Value</b> | <b>Unit</b> | <b>Test Standard</b> |
|--|--------------|-------------|----------------------|
| 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