

LEMALLOY BX503A-1

(PPE+PA6)-X

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	40 / *	cm ³ /10min	ISO 1133
Temperature	280 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	1.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	3100 / 1700	MPa	ISO 527
Yield stress	65 / 46	MPa	ISO 527
Yield strain	4.5 / 9	%	ISO 527
Strain at break	29 / 60	%	ISO 527
Flexural modulus, 23°C	2900 / 1800	MPa	ISO 178
Flexural strength	100 / 68	MPa	ISO 178
Charpy notched impact strength, +23°C	9 / 14	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	120 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	170 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1190 / -	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	70 - 110	°C	-
Zone 1	250 - 290	°C	-
Zone 2	260 - 300	°C	-
Zone 3	260 - 300	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Applications

Automotive, Electrical and Electronical, General Purpose