LEMALLOY BX504D

(PPE+PA6)-X — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**21 / ***	cm³/10min	ISO 1133
Temperature	**280 / ***	°C	-
Load	**5 / ***	kg	-
Molding shrinkage, parallel	**0.8 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**4200 / 2200**	MPa	ISO 527
Yield stress	**- / 42**	MPa	ISO 527
Yield strain	**- / 8.4**	%	ISO 527
Stress at break	**62 / -**	MPa	ISO 527
Strain at break	**6.1 / 74**	%	ISO 527
Flexural modulus, 23°C	**3650 / 2100**	MPa	ISO 178
Flexural strength	**100 / 57**	MPa	ISO 178
Charpy notched impact strength, +23°C	**6 / 12**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**95 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**180 / ***	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	**1220 / -**	kg/m³	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	-
Nozzle temperature	**260 - 300**	°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