

LEMALLOY® BX503A-1

Polyphenylene Ether + Nylon 6

Mitsubishi Engineering-Plastics Corp

Message:

LEMALLOY® BX503A-1 is a Polyphenylene Ether + Nylon 6 (PPE+Nylon 6) material filled with filler. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of LEMALLOY® BX503A-1: Rigid.

General Information				
Filler / Reinforcement		Filler		
Features		High Rigidity		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.19	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	35.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				
Across Flow : 3.20 mm	0.90 to 1.1	--	%	
Flow : 3.20 mm	1.0 to 1.2	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3100	1700	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	67.0	46.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	4.5	9.0	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	29	60	%	ISO 527-2
Flexural Modulus (23°C)	3400	1800	MPa	ISO 178
Flexural Stress (23°C)	110	68.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	14	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	180	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	120	--	°C	ISO 75-2/A
Injection	Dry	Unit		
Drying Temperature	110 to 120		°C	
Drying Time	2.0 to 4.0		hr	
Rear Temperature	250 to 290		°C	
Middle Temperature	260 to 300		°C	
Front Temperature	260 to 300		°C	
Nozzle Temperature	260 to 300		°C	

Mold Temperature	70.0 to 110	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

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Recommended distributors for this material

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