

Lucel® N127LD

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

Lucel® N127LD is an Acetal (POM) Copolymer material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Important attributes of Lucel® N127LD are:

- Flame Rated
- Chemical Resistant
- Typical applications include:
 - Business/Office Goods
 - Printing Applications

General Information			
UL YellowCard	E67171-248312	E67171-248313	
Features	Good Chemical Resistance		
Uses	Business Equipment		
	Printer Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.8 to 2.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	82		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	61.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	55	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2600	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	91.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	160	°C	
1.8 MPa, Unannealed, 6.40 mm	110	°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity (23°C)	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	24	kV/mm	ASTM D149

Dissipation Factor (1 MHz)	3.8E-4	ASTM D150	
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.710 mm	HB		
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 6.0	hr	
Minimum Moisture Content	0.10	%	
Rear Temperature	160 to 180	°C	
Middle Temperature	180 to 200	°C	
Front Temperature	190 to 200	°C	
Nozzle Temperature	190 to 200	°C	
Processing (Melt) Temp	190 to 200	°C	
Mold Temperature	60.0 to 80.0	°C	
Back Pressure	4.02 to 8.04	MPa	
Screw Speed	50 to 100	rpm	
NOTE			
1.	10 mm/min		
2.	10 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		

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