

Lucel® FW715CS

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

Description
Friction Resistance, Abrasion Resistance
Application
Gears, Printer Roller Pumps, Gear Worm Wheels

General Information			
Features	Good Abrasion Resistance		
	Low Friction		
Uses	Gears		
	Printer Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.7 to 2.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	69		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	43.2	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	120	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1990	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	64.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	50	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	92.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (0.950 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.010	%	
Rear Temperature	160 to 180	°C	
Middle Temperature	170 to 190	°C	

Front Temperature	180 to 200	°C
Nozzle Temperature	180 to 200	°C
Processing (Melt) Temp	200 to 220	°C
Mold Temperature	80.0 to 110	°C
Back Pressure	0.490 to 3.04	MPa
Screw Speed	50 to 100	rpm

NOTE

- | | |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | 18.6kg |

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