

Lucel® N109LDS

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

Description

Chemical Resistance

Application

Copyer, Watch, Clock, VCR, Printer Parts, etc.

General Information			
Features	Good Chemical Resistance		
Uses	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)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.8 to 2.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	82		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	61.3	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	60	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2550	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	90.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Annealed, 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	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength	24	kV/mm	ASTM D149
Dissipation Factor (1 MHz)	3.8E-4		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 6.0	hr	
Suggested Max Moisture	< 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	3.92 to 7.85	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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

