Lucel® HI515W

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

Description
High Impact
Application
Gears, Automobile Clip

General Information			
Additive	Rubber Impact Modifier		
Features	High Impact Resistance		
Uses	Automotive Applications Gears		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.33	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.7 to 2.0	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	64		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (Yield, 3.20 mm)	41.9	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	67	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	1420	MPa	ASTM D790
Flexural Strength [4] (Yield, 3.20 mm)	47.3	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 6.40 mm)	73	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load [5] (0.45 MPa, Unannealed, 6.40 mm)	79.0	°C	ASTM D648
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 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	80 to 110	rpm

NOTE	
1.	50 mm/min
2.	50 mm/min
3.	2.8 mm/min
4.	2.8 mm/min
5.	18.6kg

Recommended distributors for this material

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