

LEMALLOY® BX505

Polyphenylene Ether + Nylon 6

Mitsubishi Engineering-Plastics Corp

Message:

LEMALLOY® BX505 is a Polyphenylene Ether + Nylon 6 (PPE+Nylon 6) material. It is available in Asia Pacific, Europe, or North America for injection molding.

General Information				
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.09	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	19.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				
Across Flow : 3.20 mm	1.1 to 1.3	--	%	
Flow : 3.20 mm	1.2 to 1.4	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	2200	1200	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	54.0	38.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	4.2	19	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	41	120	%	ISO 527-2
Flexural Modulus (23°C)	2200	1200	MPa	ISO 178
Flexural Stress (23°C)	85.0	47.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	35	88	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	155	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	70.0	--	°C	ISO 75-2/A
CLTE - Flow	9.0E-5	--	cm/cm/°C	ISO 11359-2
Injection	Dry	Unit		
Drying Temperature	110 to 120		°C	
Drying Time	2.0 to 4.0		hr	
Rear Temperature	240 to 270		°C	
Middle Temperature	250 to 290		°C	
Front Temperature	250 to 290		°C	
Nozzle Temperature	250 to 290		°C	
Mold Temperature	60.0 to 100		°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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