

LEMALLOY® BX504D

Polyphenylene Ether + Nylon 6

Mitsubishi Engineering-Plastics Corp

Message:

LEMALLOY® BX504D is a Polyphenylene Ether + Nylon 6 (PPE+Nylon 6) material filled with filler. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of LEMALLOY® BX504D: Rigid.

General Information				
Filler / Reinforcement		Filler		
Features		High Rigidity		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.22	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	21.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				
Across Flow : 3.20 mm	0.60 to 0.80	--	%	
Flow : 3.20 mm	0.70 to 0.90	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	4200	2200	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield, 23°C	--	42.0	MPa	
Break, 23°C	62.0	--	MPa	
Tensile Strain				ISO 527-2
Yield, 23°C	--	8.4	%	
Break, 23°C	6.1	--	%	
Nominal Tensile Strain at Break (23°C)	--	74	%	ISO 527-2
Flexural Modulus (23°C)	4200	2100	MPa	ISO 178
Flexural Stress (23°C)	105	57.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	12	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	180	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	95.0	--	°C	ISO 75-2/A
Injection	Dry	Unit		
Drying Temperature	110 to 120		°C	
Drying Time	2.0 to 4.0		hr	

Rear Temperature	250 to 290	°C
Middle Temperature	260 to 300	°C
Front Temperature	260 to 300	°C
Nozzle Temperature	260 to 300	°C
Mold Temperature	70.0 to 110	°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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