

Lucel® FW720F

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

LUCEL FW-720F is the friction-resistance and abrasion-resistance grade made of acetal resin reinforced with silicon oil,fluoric resin,and macromolecular abrasion promoter.

General Information			
Additive	PTFE Lubricant (20%)		
Features	Fatigue Resistant		
	Good Abrasion Resistance		
	Good Chemical Resistance		
	Good Creep Resistance		
	Good Dimensional Stability		
	Good Moldability		
	Good Thermal Stability		
	Good Wear Resistance		
	Low Friction		
	Lubricated		
Uses	Camera Applications		
	Gears		
	Printer Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.3 to 1.6	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	49.4	MPa	ASTM D638
Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus ²	2270	MPa	ASTM D790
Flexural Strength ³ (Yield)	79.0	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Itself - Dynamic	0.13		
vs. Itself - Static	0.080		
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	7.00	mg	ASTM D1044

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	45	J/m	ASTM D256
Unnotched Izod Impact	440	J/m	ASTM D256
Reverse Notch Izod Impact	450	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Annealed, 6.35 mm	155	°C	
1.8 MPa, Annealed, 6.35 mm	100	°C	
CLTE - Flow (20 to 80°C)	1.0E-4	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 6.0	hr	
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	180 to 200	°C	
Melt Temperature (Aim)	190	°C	
Mold Temperature	60.0 to 80.0	°C	
Injection Pressure	68.6 to 118	MPa	
Back Pressure	3.92 to 7.84	MPa	
Screw Speed	50 to 100	rpm	
NOTE			
1.	50 mm/min		
2.	15 mm/min		
3.	15 mm/min		

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