

SolutionPartner


LUCEL HI510

Injection Modified POM

Description

High impact

Application

Gear, Auto mobile clip

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.38
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	1.7 ~ 2.0
Melt flow rate		ASTM D1238	g/10min	14
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@Yield	10 mm/min		kg/cm ²	550
Tensile Elongation, 3.2mm		ASTM D638		
@Break	10 mm/min		%	90
Flexural Strength, 6.4mm	2.8 mm/min	ASTM D790	kg/cm ²	660
Flexural Modulus, 6.4mm	2.8 mm/min	ASTM D790	kg/cm ²	19,000
Izod Impact Strength, 6.4mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	12.0
Rockwell Hardness	R-Scale	ASTM D785	-	70
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
	18.6 kg		°C	95
	4.6 kgf		°C	150
Flammability		UL94		
	0.98 mm		class	HB
	1.6 mm		class	
	2.5 mm		class	
	3.2 mm		class	
Electrical				
Dissipation factor		ASTM D150		
	1 MHz			
Surface Resistivity		ASTM D257	Ohm	1 x 10 ¹³
Volume Resistivity	23 °C	ASTM D257	Ohm·cm	1 x 10 ¹⁵
Dielectric Strength	23 °C	ASTM D149	kV/mm	

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
[Pre-drying]			
Drying Temperature		°C	80 ~ 110
Drying Time		hrs	2 ~ 3
Maximum Moisture Content		%	0.1
[Temperature]			
Mold temperature		°C	80 ~ 110
Cylinder Temperature	Rear		160 ~ 180
	Middle	°C	180 ~ 200
	Front	°C	190 ~ 200
Nozzle Temperature		°C	180 ~ 200
Back Pressure		bar	5 ~ 31
Screw Speed		mm/s	80 ~ 110

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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