

LEMALLOY® C82HL

Polyphenylene Ether + Nylon 66

Mitsubishi Engineering-Plastics Corp

Message:

LEMALLOY® C82HL is a Polyphenylene Ether + Nylon 66 (PPE+Nylon 66) material. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of LEMALLOY® C82HL: High Flow.

General Information				
Features	High Flow			
Forms	Pellets			
Processing Method	Injection Molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	115	--	cm ³ /10min	ISO 1133
Molding Shrinkage				
Across Flow : 3.20 mm	1.1 to 1.3	--	%	
Flow : 3.20 mm	1.1 to 1.3	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	2600	1500	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	62.0	45.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	4.8	19	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	47	88	%	ISO 527-2
Flexural Modulus (23°C)	2400	1500	MPa	ISO 178
Flexural Stress (23°C)	93.0	60.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	16	62	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	165	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	70.0	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	7.0E+14	--	ohms	IEC 60093
Volume Resistivity	2.0E+15	--	ohms · cm	IEC 60093
Electric Strength				IEC 60243-1
1.00 mm	33	--	kV/mm	
3.00 mm	18	--	kV/mm	

Relative Permittivity			IEC 60250
100 Hz	3.40	--	
1 MHz	3.20	--	
Dissipation Factor			IEC 60250
100 Hz	5.0E-3	--	
1 MHz	0.012	--	
Injection	Dry	Unit	
Drying Temperature	110 to 120	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	240 to 260	°C	
Middle Temperature	250 to 280	°C	
Front Temperature	250 to 280	°C	
Nozzle Temperature	250 to 280	°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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