

Lucel® HI520

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

Description
High Impact
Application
Gears

General Information			
UL YellowCard	E67171-248288		
Additive	Rubber Impact Modifier		
Features	High Impact Resistance		
Uses	Gears		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.7 to 2.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	60		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	41.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1480	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	54.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	135	°C	
1.8 MPa, Unannealed, 6.40 mm	85.0	°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity (23°C)	1.0E+15	ohms · cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	2.0 to 3.0	hr	
Minimum Moisture Content	0.10	%	

Rear Temperature	160 to 180	°C
Middle Temperature	170 to 190	°C
Front Temperature	180 to 200	°C
Nozzle Temperature	180 to 200	°C
Processing (Melt) Temp	200 to 220	°C
Mold Temperature	80.0 to 110	°C
Back Pressure	0.495 to 3.04	MPa
Screw Speed	50 to 100	rpm

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT