LEMALLOY® C61HL

Polyphenylene Ether + Nylon 66

Mitsubishi Engineering-Plastics Corp

Message:

LEMALLOY® C61HL is a Polyphenylene Ether + Nylon 66 (PPE+Nylon 66) material. It is available in Asia Pacific, Europe, or North America for injection molding.

General Information				
Forms	Pellets			
Processing Method	Injection Molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.10	--	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	31.0	--	cm³/10min	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)	2500	1600	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	66.0	51.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	5.3	11	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	42	73	%	ISO 527-2
Flexural Modulus (23°C)	2500	1700	MPa	ISO 178
Flexural Stress (23°C)	104	71.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	13	45	kJ/m²	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	185	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	105	--	°C	ISO 75-2/A
CLTE - Flow	9.0E-5	--	cm/cm/°C	ISO 11359-2
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	5.0E+14	--	ohms	IEC 60093
Volume Resistivity	1.0E+16	--	ohms·cm	IEC 60093
Electric Strength				IEC 60243-1
1.00 mm	30	--	kV/mm	
3.00 mm	17	--	kV/mm	

Relative Permittivity				IEC 60250
100 Hz	3.30	--		
1 MHz	3.20	--		
Dissipation Factor				IEC 60250
100 Hz	4.0E-3	--		
1 MHz	9.4E-3	--		
Injection	Dry	Unit		
Drying Temperature	110 to 120		°C	
Drying Time	2.0 to 4.0		hr	
Rear Temperature	240 to 270		°C	
Middle Temperature	250 to 290		°C	
Front Temperature	250 to 290		°C	
Nozzle Temperature	250 to 290		°C	
Mold Temperature	60.0 to 100		°C	
Injection Pressure	20.0 to 150		MPa	
Injection Rate	Moderate			
Screw Speed	60 to 150		rpm	

Recommended distributors for this material

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