

LEMALLOY™ BX528A-3

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PA 6

General Information

Product Description

Un-reinforced PPE/PA6 alloy; Rigidity, High

General

Features	• High Rigidity	
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.15	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) 280°C/5.0 kg	15	--	cm ³ /10min	ISO 1133
Molding Shrinkage				Internal Method
Across Flow : 3.20 mm	1.0 to 1.2	--	%	
Flow : 3.20 mm	1.2 to 1.4	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2500	1400	MPa	ISO 527-1/1
Tensile Stress (Yield)	62.0	37.0	MPa	ISO 527-2/50
Tensile Strain				ISO 527-2/50
Yield	5.0	15	%	
Break	57	140	%	
Flexural Modulus ²	2300	1400	MPa	ISO 178
Flexural Stress ²	91.0	60.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength 23°C	26	66	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	170	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	85.0	--	°C	ISO 75-2/A
CLTE - Flow	9.0E-5	--	cm/cm/°C	ISO 11359-2

Additional Information

Conditioned Conditioned to 50% RH

Processing Information

Injection	Dry	Unit
Drying Temperature - Hot Air Dryer	110 to 120	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	240 to 270	°C

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Injection	Dry	Unit
Middle Temperature	250 to 290	°C
Front Temperature	250 to 290	°C
Nozzle Temperature	250 to 290	°C
Mold Temperature	60 to 100	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 mm/min

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