

LEMALLOY™ PX603Y

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PP

General Information

Product Description

Un-reinforced PPE/PP alloy; Flow, good

General

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

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	0.980	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	55	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 3.20 mm	1.1 to 1.3	%	
Flow : 3.20 mm	1.0 to 1.2	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1900	MPa	ISO 527-1/1
Tensile Stress (Yield)	42.0	MPa	ISO 527-2/50
Flexural Modulus ²	1900	MPa	ISO 178
Flexural Stress ²	59.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	120	°C	

Processing Information

Injection	Nominal Value	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
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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