SolutionPartner

LG Chem

LUCEL N127LD

Injection Molding, POM

Description

Chemical resistance

Application

Copyer, Watch, Clock, VCR, Printer parts, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.41
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	1.8 ~ 2.1
Melt flow rate		ASTM D1238	g/10min	27
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@Yield	10 mm/min		kg/cm^2	630
Tensile Elongation, 3.2mm		ASTM D638		
@Break	10 mm/min		%	55
Flexural Strength, 6.4mm	2.8 mm/min	ASTM D790	kg/cm^2	930
Flexural Modulus, 6.4mm	2.8 mm/min	ASTM D790	kg/cm^2	26,500
Izod Impact Strength, 6.4mm		ASTM D256		
(Notched)	23 ℃		kg·cm/cm	6.0
Rockwell Hardness	R-Scale	ASTM D785	-	82
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
	18.6 kg		℃	110
	4.6 kgf		℃	160
Flammability		UL94		
	0.71 mm		class	HB
	1.5 mm		class	HB
	2.5 mm		class	
	3.0 mm		class	HB
Electrical				
Dissipation factor		ASTM D150		
	1 MHz			3.8
Surface Resistivity		ASTM D257	Ohm	1×10^{16}
Volume Resistivity	23 ℃	ASTM D257	Ohm·cm	1×10^{14}
Dielectric Strength	23 ℃	ASTM D149	kV/mm	24

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
[Pre-drying]			
Drying Temperature		℃	90 ~ 110
Drying Time		hrs	3 ~ 6
Maximum Moisture Content		%	0.1
[Temperature]			
Mold temperature		℃	60 ~ 80
Cylinder Temperature	Rear		160 ~ 180
	Middle	℃	180 ~ 200
	Front	℃	190 ~ 200
Nozzle Temperature		℃	190 ~ 200
Back Pressure		bar	41 ~ 82
Screw Speed		mm/s	50 ~ 100

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.