

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 @Yield	10 mm/min	ASTM D638	kg/cm ²	630
Tensile Elongation, 3.2mm @Break	10 mm/min	ASTM D638	%	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 (Notched)	23 °C	ASTM D256	kg-cm/cm	6.0
Rockwell Hardness	R-Scale	ASTM D785	-	82
Thermal				
Heat Deflection Temperature, 6.4mm	18.6 kg	ASTM D648	°C	110
	4.6 kgf		°C	160
Flammability	0.71 mm	UL94	class	HB
	1.5 mm		class	HB
	2.5 mm		class	
	3.0 mm		class	HB
Electrical				
Dissipation factor	1 MHz	ASTM D150		3.8
Surface Resistivity		ASTM D257	Ohm	1 x 10 ¹⁶
Volume Resistivity	23 °C	ASTM D257	Ohm-cm	1 x 10 ¹⁴
Dielectric Strength	23 °C	ASTM D149	kV/mm	24

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
[Pre-drying]		
Drying Temperature	°C	90 ~ 110
Drying Time	hrs	3 ~ 6
Maximum Moisture Content	%	0.1
[Temperature]		
Mold temperature	°C	60 ~ 80
Cylinder Temperature	Rear	160 ~ 180
	Middle	180 ~ 200
	Front	190 ~ 200
Nozzle Temperature	°C	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.

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