

LEMALLOY™ BX504D

Mitsubishi Engineering-Plastics Corp - Polyphenylene Ether + PA 6

General Information				
Product Description				
Filler-reinforced PPE/PA6 alloy; Rigidity, High				
General				
Filler / Reinforcement	• Filler			
Features	• High Rigidity			
Uses	• Automotive Applications • Automotive Electronics		• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.22	--	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR)				ISO 1133
280°C/5.0 kg	21	--	cm³/10min	
Molding Shrinkage				Internal Method
Across Flow : 3.20 mm	0.60 to 0.80	--	%	
Flow : 3.20 mm	0.70 to 0.90	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	4200	2200	MPa	ISO 527-1/1
Tensile Stress				ISO 527-2/5
Yield	--	42.0	MPa	
Break	62.0	--	MPa	
Tensile Strain				ISO 527-2/5
Yield	--	8.4	%	
Break	6.1	74	%	
Flexural Modulus ²	3650	2100	MPa	ISO 178
Flexural Stress ²	100	57.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	6.0	12	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	180	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	95.0	--	°C	ISO 75-2/A
Additional Information				
Conditioned	Conditioned to 50% RH			

Processing Information	
Injection	Dry Unit
Drying Temperature - Hot Air Dryer	110 to 120 °C



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Injection	Dry	Unit
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Rear Temperature	250 to 290	°C
Middle Temperature	260 to 300	°C
Front Temperature	260 to 300	°C
Nozzle Temperature	260 to 300	°C
Mold Temperature	70 to 110	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate	
Screw Speed	60 to 150	rpm

