

Lucky Enpla LAY1004H

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1004H is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LAY1004H applications include home applications and the automotive industry. Features include:
Impact resistance
Heat resistance

General Information			
Features	Impact resistance, high		
	Heat resistance, high		
Uses	Household goods		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	58.8	MPa	ASTM D638
Flexural Modulus ²	2160	MPa	ASTM D790
Flexural Strength ³	83.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	590	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	118	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	230 - 250	°C	
Middle Temperature	235 - 255	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	250 - 270	°C	
Mold Temperature	30.0 - 60.0	°C	
Back Pressure	0.490 - 1.47	MPa	
Screw Speed	40 - 70	rpm	

Injection instructions

Resin Temperature: 250-270°C Injection Pressure (1st Pressure): 800-1200 kg/cm² Injection Pressure (2nd Pressure): 300-700 kg/cm²

NOTE

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|----|-----------|
| 1. | 50 mm/min |
| 2. | 10 mm/min |
| 3. | 10 mm/min |

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