

Lucky Enpla LPC1000EX

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LPC1000EX is a polycarbonate (PC) product. It can be processed by extrusion or injection molding and is available in North America, Europe or Asia Pacific. Typical application areas are: water pipes/pipes/drinking water.

Features include:

- good weather resistance
- Heat resistance

General Information			
Features	Good weather resistance		
	Heat resistance, high		
Uses	Piping system		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	61.8	MPa	ASTM D638
Flexural Modulus ²	2350	MPa	ASTM D790
Flexural Strength ³	92.2	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	830	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	135	°C	ASTM D648

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 90.0	°C
Drying Time	2.0 - 3.0	hr
Rear Temperature	280 - 290	°C
Middle Temperature	290 - 300	°C
Front Temperature	300 - 310	°C
Nozzle Temperature	290 - 310	°C
Mold Temperature	60.0 - 80.0	°C
Back Pressure	1.96 - 3.92	MPa
Screw Speed	60 - 80	rpm

Injection instructions

Resin Temperature: 285-310°C Injection Pressure (1st Pressure): 700-1200 kg/cm² Injection Pressure (2nd Pressure): 400-800 kg/cm²

NOTE

- | | |
|----|-----------|
| 1. | 30 mm/min |
| 2. | 30 mm/min |
| 3. | 30 mm/min |

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