

Lucky Enpla LAY8008

Acrylonitrile Styrene Acrylate + PC

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY8008 is an acrylonitrile-styrene-acrylate PC (ASA PC) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Typical application areas are: automotive industry. The main characteristics are: good weather resistance.

General Information			
Features	Good weather resistance		
Uses	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)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	53.9	MPa	ASTM D638
Flexural Modulus ²	2110	MPa	ASTM D790
Flexural Strength ³	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	490	J/m	ASTM D256
6.35 mm	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	115	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	240 - 270	°C	
Middle Temperature	250 - 270	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	260 - 280	°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°CInjection Pressure (1st Pressure): 800-1200 kg/cm²Injection Pressure (2nd Pressure): 500-800 kg/cm²			
NOTE			
1.	50 mm/min		

2.	10 mm/min
3.	10 mm/min

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