

Lucky Enpla LPC1006SG

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LPC1006SG is a polycarbonate (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.
Features include:
high gloss
good weather resistance

General Information			
Features	Highlight		
	Good weather resistance		
Uses	Application in Automobile Field		
Processing Method	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)	12	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	2300	MPa	ASTM D790
Flexural Strength ³	91.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	780	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	132	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	280 - 300	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	280 - 300	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			
Resin Temperature: 290-310°CInjection Pressure (1st Pressure): 700-1200 kg/cm²Injection Pressure (2nd Pressure): 400-800 kg/cm²			
NOTE			

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

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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