Lucky Enpla LAY1004SG

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1004SG 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. Typical application areas are: automotive industry.
Features include:
high gloss
Heat resistance

General Information			
Features	Highlight		
	Heat resistance, high		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength [1]	59.8	MPa	ASTM D638
Flexural Modulus [2]	2160	MPa	ASTM D790
Flexural Strength [3]	82.4	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)	119	°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	230 - 250	°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°CInjection Pressure (1st Pressure): 800-1200 kg/cm²Injection Pressure (2nd Pressure): 300-700 kg/cm²			

NOTE	
1.	50 mm/min
2.	10 mm/min
3.	10 mm/min

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