

# Lucky Enpla LAY7000

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Lucky Enpla Co LTD

## Message:

Lucky Enpla LAY7000 is an acrylonitrile butadiene styrene acrylic acid (PMMA)(ABS acrylic acid) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Typical application areas are: electrical/electronic applications. The main characteristics are: high gloss.

General Information			
Features	Highlight		
	Good liquidity		
Uses	Electrical/Electronic Applications		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	53.9	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	2450	MPa	ASTM D790
Flexural Strength <sup>3</sup>	76.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	110	J/m	ASTM D256
6.35 mm	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	83.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	210 - 230	°C	
Middle Temperature	220 - 240	°C	
Front Temperature	220 - 240	°C	
Nozzle Temperature	220 - 240	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			

Resin Temperature: 210-230°C Injection Pressure (1st Pressure): 700-1200 kg/cm<sup>2</sup> Injection Pressure (2nd Pressure): 400-800 kg/cm<sup>2</sup>

#### NOTE

- |    |           |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 15 mm/min |
| 3. | 15 mm/min |

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#### Recommended distributors for this material

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