

# Lucky Enpla LAY1004EX

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1004EX is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It can be processed by extrusion or injection molding and is available in North America, Europe or Asia Pacific.

Features include:

high strength

Heat resistance

General Information			
Features	High strength		
	Heat resistance, high		
Uses	Profile		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	61.8	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	2260	MPa	ASTM D790
Flexural Strength <sup>3</sup>	89.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	120	°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	235 - 255	°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°C Injection Pressure (1st Pressure): 800-1200 kg/cm<sup>2</sup> Injection Pressure (2nd Pressure): 300-700 kg/cm<sup>2</sup>

#### NOTE

- |    |           |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 10 mm/min |
| 3. | 10 mm/min |

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

#### Recommended distributors for this material

### 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

