

Lucky Enpla LGF5408A

Polyamide 66
Lucky Enpla Co LTD

Message:

Lucky Enpla LGF5408A is a polyamide 66 (nylon 66) product that contains 40% glass \minerals. 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.

General Information			
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	137	MPa	ASTM D638
Flexural Modulus ²	7650	MPa	ASTM D790
Flexural Strength ³	216	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (6.35 mm)	54	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	235	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	240 - 260	°C	
Middle Temperature	250 - 270	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	260 - 280	°C	
Mold Temperature	80.0 - 110	°C	
Back Pressure	0.490 - 1.96	MPa	
Screw Speed	40 - 70	rpm	
Injection instructions			
Resin Temperature: 250-270°CInjection Pressure (1st Pressure): 800-1300 kg/cm²Injection Pressure (2nd Pressure): 500-800 kg/cm²			
NOTE			
1.	5.0 mm/min		
2.	3.0 mm/min		
3.	3.0 mm/min		

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