

# Lucky Enpla LMA1003

Polymethyl Methacrylate Acrylic

Lucky Enpla Co LTD

Message:

Lucky Enpla LMA1003 is a polymethyl methacrylate-acrylic acid product. It can be processed by extrusion or injection molding and is available in North America, Europe or Asia Pacific. Lucky Enpla LMA1003 applications include electrical/electronic applications, housing and automotive industries.

General Information			
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
	Shell		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	2.9	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	49.0	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	2450	MPa	ASTM D790
Flexural Strength <sup>3</sup>	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (6.35 mm)	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	84.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	220 - 240	°C	
Middle Temperature	220 - 240	°C	
Front Temperature	230 - 250	°C	
Nozzle Temperature	230 - 250	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			
Resin Temperature: 220-240°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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