

Lucky Enpla LAY1000 9309

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1000 9309 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: electrical/electronic applications.

General Information			
Features	General		
Uses	Electrical/Electronic Applications		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 - 0.65	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	50.0	MPa	ASTM D638
Flexural Modulus ²	2160	MPa	ASTM D790
Flexural Strength ³	73.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	470	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	115	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	3.0 - 5.0	hr	
Rear Temperature	250 - 270	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	265 - 285	°C	
Nozzle Temperature	270 - 290	°C	
Mold Temperature	50.0 - 80.0	°C	
Back Pressure	0.490 - 2.94	MPa	
Screw Speed	30 - 50	rpm	
Injection instructions			
Resin Temperature: 250-270°CInjection Pressure (1st Pressure): 700-1200 kg/cm²Injection Pressure (2nd Pressure): 500-900 kg/cm²			
NOTE			
1.	50 mm/min		
2.	10 mm/min		
3.	10 mm/min		

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Recommended distributors for this material

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