

Lucky Enpla LPC1000 9321

Polycarbonate

Lucky Enpla Co LTD

Message:

Lucky Enpla LPC1000 9321 is a polycarbonate (PC) product. It is available in North America, Europe or Asia Pacific. Typical application areas are: electrical/electronic applications. The main characteristics are: flame retardant/rated flame.

General Information			
Features	General		
Uses	Communication application		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 - 0.62	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	53.9	MPa	ASTM D638
Flexural Modulus ²	2260	MPa	ASTM D790
Flexural Strength ³	83.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	128	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (0.800 mm)	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	3.0 - 5.0	hr	
Rear Temperature	280 - 295	°C	
Middle Temperature	285 - 305	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	290 - 310	°C	
Mold Temperature	50.0 - 80.0	°C	
Back Pressure	0.981 - 2.94	MPa	
Screw Speed	30 - 50	rpm	
Injection instructions			
Resin Temperature: 290-315°CInjection Pressure (1st Pressure): 800-1200 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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