

Lucky Enpla LKI

Acrylonitrile Butadiene Styrene

Lucky Enpla Co LTD

Message:

Lucky Enpla LKI is an acrylonitrile butadiene styrene (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. The main characteristics are: impact resistance.

General Information			
Features	Impact resistance, high		
Uses	Electrical/Electronic Applications		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.1	MPa	ASTM D638
Flexural Modulus ²	2450	MPa	ASTM D790
Flexural Strength ³	72.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	340	J/m	ASTM D256
6.35 mm	340	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	92.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	200 - 220	°C	
Middle Temperature	210 - 230	°C	
Front Temperature	210 - 230	°C	
Nozzle Temperature	220 - 240	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			
Resin Temperature: 210-230°CInjection Pressure (1st Pressure): 700-1200 kg/cm²Injection Pressure (2nd Pressure): 400-800 kg/cm²			
NOTE			
1.	50 mm/min		

2.	10 mm/min
3.	10 mm/min

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