

Lucky Enpla LAY1001F

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1001F is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It is available in North America, Europe or Asia Pacific. Lucky Enpla LAY1001F applications include electrical/electronic applications and housing.

Features include:

flame retardant/rated flame

high liquidity

Impact resistance

Halogen-free

General Information			
UL YellowCard	E217401-545990		
Features	Impact resistance, good		
	High liquidity		
	Halogen-free		
Uses	Computer components		
	Electrical/Electronic Applications		
	Electrical housing		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	58.8	MPa	ASTM D638
Flexural Modulus ²	2450	MPa	ASTM D790
Flexural Strength ³	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	590	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	91.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	230 - 250	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	240 - 260	°C	

Nozzle Temperature	240 - 260	°C
Mold Temperature	30.0 - 60.0	°C
Back Pressure	0.490 - 1.47	MPa
Screw Speed	40 - 70	rpm

Injection instructions

Resin Temperature: 240-260°C Injection Pressure (1st Pressure): 800-1200 kg/cm² Injection Pressure (2nd Pressure): 300-700 kg/cm²

NOTE

1.	50 mm/min
2.	10 mm/min
3.	10 mm/min

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