

Lucky Enpla LGF1200

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LGF1200 is a polycarbonate (PC) product that contains 20% glass fiber reinforced materials. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LGF1200 applications include electrical/electronic applications and lighting equipment.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Uses	Lighting Applications		
	Electrical/Electronic Applications		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	98.1	MPa	ASTM D638
Flexural Modulus ²	5390	MPa	ASTM D790
Flexural Strength ³	157	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	144	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	280 - 300	°C	
Middle Temperature	290 - 310	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	280 - 310	°C	
Mold Temperature	90.0 - 110	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			
Resin Temperature: 290-310°CInjection Pressure (1st Pressure): 700-1200 kg/cm²Injection Pressure (2nd Pressure): 400-800 kg/cm²			
NOTE			
1.	10 mm/min		
2.	5.0 mm/min		

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