

Lucky Enpla LPC1008F

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LPC1008F is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Typical application areas are: lighting equipment.

Features include:

- flame retardant/rated flame
- Flame Retardant
- Heat resistance

General Information			
Features	Heat resistance, high		
	Flame retardancy		
Uses	Lighting Applications		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	62.8	MPa	ASTM D638
Flexural Modulus ²	2210	MPa	ASTM D790
Flexural Strength ³	89.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	129	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (3.20 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	270 - 290	°C	
Middle Temperature	270 - 290	°C	
Front Temperature	280 - 300	°C	
Nozzle Temperature	280 - 300	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			

Resin Temperature: 290-310°C Injection Pressure (1st Pressure): 700-1200 kg/cm² Injection Pressure (2nd Pressure): 400-800 kg/cm²

NOTE

1.	30 mm/min
2.	30 mm/min
3.	30 mm/min

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