

Lucky Enpla LMF3250

Polybutylene Terephthalate

Lucky Enpla Co LTD

Message:

Lucky Enpla LMF3250 is a polybutene terephthalate (PBT) product, which contains 25% mineral fillers. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Typical application areas are: automotive industry. The main characteristics are: beautiful.

General Information			
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Features	Excellent appearance		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 1.2	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	53.9	MPa	ASTM D638
Flexural Modulus ²	5200	MPa	ASTM D790
Flexural Strength ³	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	34	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	200	°C	ASTM D648
1.8 MPa, not annealed	105	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	220 - 240	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 265	°C	
Mold Temperature	80.0 - 110	°C	
Back Pressure	0.490 - 2.94	MPa	
Screw Speed	30 - 60	rpm	
Injection instructions			
Resin Temperature: 230-250°CInjection Pressure (1st Pressure): 700-1200 kg/cm²Injection Pressure (2nd Pressure): 400-800 kg/cm²			
NOTE			
1.	10 mm/min		
2.	3.0 mm/min		

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