

Lucky Enpla LMF5400

Polyamide 6

Lucky Enpla Co LTD

Message:

Lucky Enpla LMF5400 is a polyamide 6 (nylon 6) product that contains 40% mineral fillers. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LMF5400 applications include electrical/electronic applications and the automotive industry.

General Information			
Filler / Reinforcement	Mineral filler, 40% filler by weight		
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	83.4	MPa	ASTM D638
Flexural Modulus ²	6370	MPa	ASTM D790
Flexural Strength ³	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (6.35 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	175	°C	ASTM D648
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	240 - 260	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 270	°C	
Mold Temperature	80.0 - 110	°C	
Back Pressure	0.490 - 1.96	MPa	
Screw Speed	40 - 70	rpm	
Injection instructions			
Resin Temperature: 250-270°CInjection Pressure (1st Pressure): 800-1300 kg/cm ² Injection Pressure (2nd Pressure): 500-800 kg/cm ²			
NOTE			
1.	5.0 mm/min		
2.	3.0 mm/min		

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