

Lucky Enpla LPC1003

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LPC1003 is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LPC1003 applications include electrical/electronic applications and housing.

Features include:

- Impact resistance
- chemical resistance

General Information			
UL YellowCard	E217401-101474743		
Features	Impact resistance, good		
	Good chemical resistance		
Uses	Electrical/Electronic Applications		
	Electrical housing		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	58.8	MPa	ASTM D638
Flexural Modulus ²	2260	MPa	ASTM D790
Flexural Strength ³	91.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	740	J/m	ASTM D256
6.35 mm	390	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	130	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	270 - 280	°C	
Middle Temperature	280 - 290	°C	
Front Temperature	290 - 300	°C	
Nozzle Temperature	285 - 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: 285-310°CInjection Pressure (1st Pressure): 700-1200 kg/cm ² Injection Pressure (2nd Pressure): 400-800 kg/cm ²		
NOTE		
1.	30 mm/min	
2.	30 mm/min	
3.	30 mm/min	

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