

Lucky Enpla LPPC1000

Polyphthalate Carbonate

Lucky Enpla Co LTD

Message:

Lucky Enpla LPPC1000 is a polyester carbonate (PPC) product. 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.

General Information			
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.80 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	68.6	MPa	ASTM D638
Flexural Modulus ²	2300	MPa	ASTM D790
Flexural Strength ³	94.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	120	J/m	ASTM D256
6.35 mm	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	148	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	320 - 340	°C	
Middle Temperature	330 - 350	°C	
Front Temperature	330 - 350	°C	
Nozzle Temperature	340 - 360	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			
Resin Temperature: 320-340°CInjection Pressure (1st Pressure): 700-1200 kg/cm ² Injection Pressure (2nd Pressure): 400-800 kg/cm ²			
NOTE			
1.	5.0 mm/min		
2.	3.0 mm/min		
3.	3.0 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

