

# Lucky Enpla LMF6300

Polypropylene

Lucky Enpla Co LTD

## Message:

Lucky Enpla LMF6300 is a polypropylene product that contains 30% mineral fillers. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LMF6300 applications include electrical/electronic applications and the automotive industry.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.70 - 1.2	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	34.3	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	3140	MPa	ASTM D790
Flexural Strength <sup>3</sup>	50.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (6.35 mm)	25	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	140	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	200 - 220	°C	
Middle Temperature	200 - 220	°C	
Front Temperature	210 - 230	°C	
Nozzle Temperature	210 - 230	°C	
Mold Temperature	30.0 - 60.0	°C	
Back Pressure	0.490 - 1.47	MPa	
Screw Speed	40 - 70	rpm	
Injection instructions			
Resin Temperature: 210-230°CInjection Pressure (1st Pressure): 500-800 kg/cm <sup>2</sup> Injection Pressure (2nd Pressure): 300-600 kg/cm <sup>2</sup>			
NOTE			
1.	50 mm/min		
2.	30 mm/min		
3.	30 mm/min		

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