

Lucky Enpla LAY3003

Polycarbonate + PBT

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY3003 is a polycarbonate polybutene terephthalate (PC PBT) 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.

Features include:

Good dimensional stability

Impact resistance

General Information			
Features	Good dimensional stability		
	Impact resistance, high		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.70 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	59.8	MPa	ASTM D638
Flexural Modulus ²	2260	MPa	ASTM D790
Flexural Strength ³	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	590	J/m	ASTM D256
6.35 mm	490	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	240 - 270	°C	
Middle Temperature	250 - 270	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	260 - 280	°C	
Mold Temperature	30.0 - 60.0	°C	
Back Pressure	0.490 - 1.47	MPa	
Screw Speed	40 - 70	rpm	
Injection instructions			
Resin Temperature: 250-270°CInjection Pressure (1st Pressure): 800-1200 kg/cm²Injection Pressure (2nd Pressure): 500-800 kg/cm²			

NOTE	
1.	50 mm/min
2.	10 mm/min
3.	10 mm/min

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