

Lucky Enpla LAY2000

Polycarbonate + PET

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY2000 is a polycarbonate PET (PC PET) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Typical application areas are: kitchen utensils.

Features include:

Impact resistance

chemical resistance

General Information			
Features	Impact resistance, high		
	Good chemical resistance		
Uses	Table products		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.70 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	56.9	MPa	ASTM D638
Flexural Modulus ²	2160	MPa	ASTM D790
Flexural Strength ³	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	690	J/m	ASTM D256
6.35 mm	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	117	°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	30.0 - 60.0	°C	
Back Pressure	0.490 - 1.47	MPa	
Screw Speed	40 - 70	rpm	
Injection instructions			

Resin Temperature: 250-270°C Injection Pressure (1st Pressure): 800-1200 kg/cm² Injection Pressure (2nd Pressure): 300-700 kg/cm²

NOTE

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

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