

# Lucky Enpla LAY1004

Polycarbonate + ABS

Lucky Enpla Co LTD

## Message:

Lucky Enpla LAY1004 is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LAY1004 applications include electrical/electronic applications and the automotive industry.

Features include:

Good flexibility

Heat resistance

General Information			
Features	Good flexibility		
	Heat resistance, high		
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	55.9	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	2210	MPa	ASTM D790
Flexural Strength <sup>3</sup>	80.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	540	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)	112	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	230 - 240	°C	
Middle Temperature	230 - 250	°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°CInjection Pressure (1st Pressure): 800-1200 kg/cm <sup>2</sup> Injection Pressure (2nd Pressure): 300-700 kg/cm <sup>2</sup>		
NOTE		
1.	50 mm/min	
2.	10 mm/min	
3.	10 mm/min	

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#### Recommended distributors for this material

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