

Lucky Enpla LHLD1015

Polycarbonate
Lucky Enpla Co LTD

Message:

Lucky Enpla LHLD1015 is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. Lucky Enpla LHLD1015 applications include the automotive industry and lighting equipment.

Features include:

Light Diffusion

Heat resistance

General Information			
Features	Good Light Diffusion		
	Heat resistance, high		
Uses	Lighting Applications		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	60.3	MPa	ASTM D638
Flexural Modulus ²	2160	MPa	ASTM D790
Flexural Strength ³	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	128	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	270 - 280	°C	
Middle Temperature	280 - 290	°C	
Front Temperature	290 - 300	°C	
Nozzle Temperature	285 - 300	°C	
Mold Temperature	60.0 - 80.0	°C	
Back Pressure	1.96 - 3.92	MPa	
Screw Speed	60 - 80	rpm	
Injection instructions			

Resin Temperature: 285-310°C Injection Pressure (1st Pressure): 700-1200 kg/cm² Injection Pressure (2nd Pressure): 400-800 kg/cm²

NOTE

1.	10 mm/min
2.	5.0 mm/min
3.	5.0 mm/min

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