

# Lucky Enpla LAY1003HM

Polycarbonate + ABS

Lucky Enpla Co LTD

Message:

Lucky Enpla LAY1003HM 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 LAY1003HM applications include home applications and coating applications.

Features include:

- Impact resistance
- good weather resistance
- Heat resistance

| General Information                                     |                              |                   |             |
|---|------------------------------|-------------------|-------------|
| Features  | Ultra-high impact resistance |                   |             |
|   | Good weather resistance      |                   |             |
|   | Heat resistance, high        |                   |             |
| Uses  | Protective cover             |                   |             |
|   | Household goods              |                   |             |
| Processing Method                                       | Injection molding            |                   |             |
| Physical  | Nominal Value                | Unit              | Test Method |
| Specific Gravity  | 1.18                         | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)               | 9.0                          | 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>                           | 58.8                         | MPa               | ASTM D638   |
| Flexural Modulus <sup>2</sup>                           | 2220                         | MPa               | ASTM D790   |
| Flexural Strength <sup>3</sup>                          | 78.5                         | 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) | 113                          | °C                | ASTM D648   |
| Injection   | Nominal Value                | Unit              |             |
| Drying Temperature                                      | 70.0 - 90.0                  | °C                |             |
| Drying Time   | 2.0 - 3.0                    | hr                |             |
| Rear Temperature  | 230 - 260                    | °C                |             |
| Middle Temperature                                      | 240 - 260                    | °C                |             |
| Front Temperature                                       | 240 - 270                    | °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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