

# Lucky Enpla LAY3003R

Polycarbonate + PBT

Lucky Enpla Co LTD

## Message:

Lucky Enpla LAY3003R 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:

Impact resistance

good weather resistance

General Information			
Features	Impact resistance, high		
	Low temperature impact resistance		
	Good weather resistance		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.70 - 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>	2160	MPa	ASTM D790
Flexural Strength <sup>3</sup>	86.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
-30°C, 3.18 mm	130	J/m	ASTM D256
23°C, 3.18 mm	740	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	103	°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°C Injection Pressure (1st Pressure): 800-1200 kg/cm<sup>2</sup> Injection Pressure (2nd Pressure): 500-800 kg/cm<sup>2</sup>

#### NOTE

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

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