

Lucky Enpla LGF3110R

Polycarbonate + PBT

Lucky Enpla Co LTD

Message:

Lucky Enpla LGF3110R is a polycarbonate + polybutene terephthalate (PC + PBT) product, which contains a 11% glass fiber reinforced material. 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:

Good flexibility

Impact resistance

chemical resistance

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 11% filler by weight		
Features	Impact resistance, high		
	Good flexibility		
	Good chemical resistance		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.70 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	82.4	MPa	ASTM D638
Flexural Modulus ²	3870	MPa	ASTM D790
Flexural Strength ³	127	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact			ASTM D256
3.18 mm	69	J/m	ASTM D256
6.35 mm	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	115	°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	260 - 280	°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: 260-280°CInjection Pressure (1st Pressure): 800-1200 kg/cm ² Injection Pressure (2nd Pressure): 500-800 kg/cm ²		
NOTE		
1.	10 mm/min	
2.	3.0 mm/min	
3.	3.0 mm/min	

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