

EnCom PC-PBT 1174SP

Polycarbonate + PBT

EnCom, Inc.

Message:

Impact Modified Molding Grade PC/PBT Alloy

General Information			
Additive	Impact Modifier		
Features	High Impact Resistance		
	Impact Modified		
Uses	Automotive Applications		
	Lawn and Garden Equipment		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	1.7 to 2.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	53.4	MPa	ASTM D638
Flexural Modulus	1850	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	270	J/m	
0°C	170	J/m	
23°C	960	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	105	°C	

1.8 MPa, Unannealed	62.8	°C
Injection	Nominal Value	Unit
Drying Temperature	110 to 121	°C
Drying Time	2.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	243 to 271	°C
Middle Temperature	249 to 277	°C
Front Temperature	257 to 282	°C
Nozzle Temperature	254 to 274	°C
Processing (Melt) Temp	260 to 279	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 75	rpm

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