

ENVIROLOY® ENV15-NC280

Polycarbonate + ABS

ENVIROPLAS®, Inc.

Message:

Injection Molding Grade, Low Gloss, UV Stabilized, Interior Automotive Trim Applications, RoHS Compliant

NC280 = To Be Assigned 5 Digit Number Indicating Natural, Black, or Custom Color.

The ENV15 Series Products Are Available With Mold Release and/or UV Stabilizer.

General Information			
Additive	UV Stabilizer		
Features	Good UV Resistance		
	Low Gloss		
Uses	Automotive Interior Trim		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	53.8	MPa	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	2260	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	320	J/m	
23°C	530	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	107	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 90	mm/min	FMVSS 302
Optical	Nominal Value		Test Method
Gardner Gloss (60°, Untextured)	32		ASTM D523

Injection	Nominal Value	Unit
Drying Temperature	104	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	254 to 293	°C
Middle Temperature	254 to 293	°C
Front Temperature	266 to 304	°C
Nozzle Temperature	274 to 307	°C
Mold Temperature	65.6 to 87.8	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm

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