

EnCom PC-PET 1013IM

Polycarbonate + PET

EnCom, Inc.

Message:

Molding Grade PC/PET Alloy

General Information	
Features	High Impact Resistance
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	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.70 to 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	52.4	MPa	ASTM D638
Flexural Modulus	1920	MPa	ASTM D790
Flexural Strength (Yield)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	270	J/m	
23°C	670	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	133	°C	
1.8 MPa, Unannealed	126	°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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