

EnCom F2 PC 1015

Polycarbonate

EnCom, Inc.

Message:

PreColored UL94 V-2 PC

General Information			
Uses	Electrical/Electronic Applications		
Appearance	Black		
	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	65.5	MPa	ASTM D638
Tensile Elongation (Break)	110	%	ASTM D638
Flexural Modulus	2220	MPa	ASTM D790
Flexural Strength (Yield)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	850	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	137	°C	
1.8 MPa, Unannealed	132	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.57 mm	V-2		
3.18 mm	V-2		
Injection	Nominal Value	Unit	
Drying Temperature	104 to 121	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	7.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 75	%	

Rear Temperature	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	288 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.1 to 98.9	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 70	rpm
Vent Depth	0.038 to 0.076	mm

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