

EnCom PC 1612 UR

Polycarbonate

EnCom, Inc.

Message:

General Purpose Molding Grade PC with UV and Release

General Information	
Additive	Mold Release
	UV Stabilizer
Features	General Purpose
Uses	Automotive Applications
	Business Equipment
	Thin-walled Parts
Appearance	Black
	Colors Available
	Natural Color
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)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60	%	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)	640	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 (1.57 mm)	HB		UL 94

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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