

EnCom GF PC-Polyester 1250

Polycarbonate + Polyester

EnCom, Inc.

Message:

Specialty Filled PC/Polyester Alloy

General Information			
Filler / Reinforcement	Proprietary		
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	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	68.6	MPa	ASTM D638
Flexural Modulus	3280	MPa	ASTM D790
Flexural Strength (Yield)	112	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	135	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (3.18 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	87.8 to 110	°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	18.3 to 65.6	°C
Back Pressure	0.172 to 0.689	MPa
Screw Speed	20 to 100	rpm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

