

DualPoly 2002

PPC



Product Description				
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General Properties				
Appearance	Natural			
Processing Methods	Injection Molding			
Applications	Automotive, Material Handling, Lawn & Garden			
Mechanical Properties	Test Method	English Units		S.I. Units
Tensile Strength @ Yield	ASTM D638	3,200	psi	22 MPa
Tensile Elongation at Break	ASTM D638	>20	%	>20 %
Flexural Modulus	ASTM D790	170,000	psi	1,172 MPa
Notched Izod Impact (73°F)	ASTM D256	2.0	ft-lb/in	106 J/m
Physical Properties	Test Method	English Units		S.I. Units
Specific Gravity	ASTM D792	0.90	sp gr	0.90 sp gr
Melt Flow 230°C/2.16 kg	ASTM D1238	20.0	g/10min	20.0 g/10min
Thermal Properties	Test Method	English Units		S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	185	°F	85 °C
Injection Molding		Value		
Suggested Maximum Moisture		0.02	%	
Suggested Shot Size		25 - 75	%	
Rear Barrel Temperatures		350 - 400	°F	
Middle Barrel Temperatures		360 - 410	°F	
Front Barrel Temperatures		370 - 420	°F	
Nozzle Temperature		370 - 420	°F	
Melt (processing) Temperatures		380 - 420	°F	
Mold Temperatures		90 - 160	°F	
Back Pressure		25 - 100	psi	
Screw speed		Slow - Medium	rpm	
Vent Depth		0.0010 - 0.0015	in	

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.

EnCom Polymers, Inc.

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