

# EnCounter 1814UXR-HR

PC/PBT



| Product Description  |  |                 |          |               |         |
|--|--|-----------------|----------|---------------|---------|
| Impact Modified Molding Grade PC/PBT Alloy with UV Stabilizer<br>Excellent Impact Across a Wide Temperature Range<br>Hydrolysis Resistant<br>Extra Release for Ease of Demolding |  |                 |          |               |         |
| General Properties   |  |                 |          |               |         |
| Appearance   | Black, Natural or Colors                       |                 |          |               |         |
| Processing Methods   | Injection Molding, Profile Extrusion           |                 |          |               |         |
| Applications   | Automotive, Lawn and Garden, Material Handling |                 |          |               |         |
| Mechanical Properties  | Test Method                                    | English Units   |          | S.I. Units    |         |
| Tensile Strength @ Yield   | ASTM D638                                      | 7,500           | psi      | 52            | MPa     |
| Tensile Elongation at Break  | ASTM D638                                      | 150             | %        | 150           | %       |
| Flexural Modulus   | ASTM D790                                      | 320,000         | psi      | 2,207         | MPa     |
| Flexural Strength  | ASTM D790                                      | 10,000          | psi      | 69            | MPa     |
| Notched Izod Impact (73°F)   | ASTM D256                                      | 14.0            | ft-lb/in | 748           | J/m     |
| Notched Izod Impact (-40°F)  | ASTM D256                                      | 7.0             | ft-lb/in | 374           | J/m     |
| Physical Properties  | Test Method                                    | English Units   |          | S.I. Units    |         |
| Specific Gravity   | ASTM D792                                      | 1.19            | sp gr    | 1.19          | sp gr   |
| Melt Flow                      250°C/5.0 kg  | ASTM D1238                                     | 16.0            | g/10min  | 16.0          | g/10min |
| Mold Shrink - Flow: 0.126 in (3.20 mm)   | ASTM D955                                      | 0.008 - 0.010   | in/in    | 0.008 - 0.010 | mm/mm   |
| Thermal Properties   | Test Method                                    | English Units   |          | S.I. Units    |         |
| Heat Deflection Temperature @ 66 psi   | ASTM D648                                      | 225             | °F       | 107           | °C      |
| Heat Deflection Temperature @ 264 psi  | ASTM D648                                      | 210             | °F       | 99            | °C      |
| Injection Molding  |  | Value           |          |               |         |
| Drying Temperature   |  | 220 - 250       | °F       |               |         |
| Drying Time  |  | 3.0 - 6.0       | hrs      |               |         |
| Maximum Drying Time  |  | 7.0             | hrs      |               |         |
| Suggested Maximum Moisture   |  | 0.02            | %        |               |         |
| Rear Barrel Temperatures   |  | 480 - 540       | °F       |               |         |
| Middle Barrel Temperatures   |  | 490 - 550       | °F       |               |         |
| Front Barrel Temperatures  |  | 500 - 570       | °F       |               |         |
| Nozzle Temperature   |  | 525 - 575       | °F       |               |         |
| Melt (processing) Temperatures   |  | 530 - 585       | °F       |               |         |
| Mold Temperatures  |  | 150 - 200       | °F       |               |         |
| Back Pressure  |  | 50 - 100        | psi      |               |         |
| Screw speed  |  | 40 - 75         | rpm      |               |         |
| Vent Depth   |  | 0.0015 - 0.0030 | in       |               |         |

# EnCounter 1814UXR-HR

PC/PBT



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.

812-421-7700 • [www.encompolymers.com](http://www.encompolymers.com)