

Product Description					
BPA Free Polyester Copolymer					
General Properties					
Appearance	Water Clear				
Processing Methods	Injection Molding				
Applications	Molded parts requiring excellent clarity, UV and chemical resistance FDA Food Contact Rating				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	6,500	psi	45	MPa
Tensile Elongation at Break	ASTM D638	300	%	300	%
Flexural Modulus	ASTM D790	260,000	psi	1,793	MPa
Flexural Strength	ASTM D790	9,700	psi	67	MPa
Notched Izod Impact (73°F)	ASTM D256	15.0	ft-lb/in	801	J/m
Un-notched izod	ASTM D256	29.0	ft-lb/in	1549	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.23	sp gr	1.23	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003 - 0.005	in/in	0.127 - 0.178	mm/mm
Rockwell Hardness (R-Scale)	ASTM D785	105		105	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	158	°F	70	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	144	°F	62	°C
Injection Molding		Value			
Drying Temperature		190	°F		
Drying Time		4.0 - 6.0	hrs		
Suggested Maximum Moisture		0.2	%		
Suggested Shot Size		25-75	%		
Rear Barrel Temperatures		470 - 500	°F		
Middle Barrel Temperatures		480 - 510	°F		
Front Barrel Temperatures		490 - 520	°F		
Nozzle Temperature		490 - 520	°F		
Melt (processing) Temperatures		500 - 540	°F		
Mold Temperatures		90 - 150	°F		
Back Pressure		25-75	psi		
Screw speed		25-75	rpm		
Vent Depth		0.001	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.

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