

EnCounter 31012U

PC/PBT



Product Description			
Impact Modified, Molding Grade PC/PBT with UV Stabilizer			
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	90 %	90 %
Flexural Modulus	ASTM D790	330,000 psi	2,276 MPa
Flexural Strength	ASTM D790	8,000 psi	55 MPa
Notched Izod Impact (73°F)	ASTM D256	12.0 ft-lb/in	641 J/m
Notched Izod Impact (-22°F)	ASTM D256	2.0 ft-lb/in	107 J/m
Physical Properties	Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.22 sp gr	1.22 sp gr
Melt Flow 266°C/5.0 kg	ASTM D1238	10.0 g/10min	10.0 g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.014 - 0.020 in/in	0.014 - 0.020 mm/mm
Thermal Properties	Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	210 °F	99 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	140 °F	60 °C
Injection Molding	Value		
Drying Temperature	200-230 °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		

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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