

EnCounter 32012U

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	9,000 psi	62 MPa
Tensile Elongation at Break	ASTM D638	100 %	100 %
Flexural Modulus	ASTM D790	350,000 psi	2,414 MPa
Flexural Strength	ASTM D790	13,500 psi	93 MPa
Notched Izod Impact (73°F)	ASTM D256	12.0 ft-lb/in	641 J/m
Notched Izod Impact (-40°F)	ASTM D256	2.0 ft-lb/in	107 J/m
Physical Properties	Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.21 sp gr	1.21 sp gr
Melt Flow 260°C/5.0 kg	ASTM D1238	20.0 g/10min	20.0 g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.010 - 0.012 in/in	0.254 - 0.305 mm/mm
Thermal Properties	Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	240 °F	116 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	220 °F	104 °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		

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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