

EnCounter 32614U

PC/PBT



Product Description					
Impact Modified Molding Grade PC/PBT Alloy with UV Stabilizer, Excellent Impact Across Wide Temperature Range					
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	8,800	psi	61	MPa
Tensile Elongation at Break	ASTM D638	110	%	110	%
Flexural Modulus	ASTM D790	350,000	psi	2,414	MPa
Flexural Strength	ASTM D790	12,000	psi	83	MPa
Notched Izod Impact (73°F)	ASTM D256	14.0	ft-lb/in	748	J/m
Notched Izod Impact (-40°F)	ASTM D256	3.5	ft-lb/in	187	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.23	sp gr	1.23	sp gr
Melt Flow 266°C/5.0 kg	ASTM D1238	26.0	g/10min	26.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.007 - 0.009	in/in	0.007 - 0.009	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	215	°F	102	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	190	°F	88	°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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