

EnCounter 410GF2502

PC/Polyester



Product Description					
10% Glass Fiber Reinforced PC Polyester Blend					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Automotive, Electrical, Material Handling				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	10,000	psi	69	MPa
Tensile Elongation at Break	ASTM D638	>15	%	>15	%
Flexural Modulus	ASTM D790	425,000	psi	2,931	MPa
Flexural Strength	ASTM D790	15,000	psi	103	MPa
Notched Izod Impact (73°F)	ASTM D256	2.0	ft-lb/in	107	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.30	sp gr	1.30	sp gr
Melt Flow 260°C/5.0 kg	ASTM D1238	25.0	g/10min	25.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.008	in/in	0.203	mm/mm
Filler Content		10.0	%	10.0	%
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	320	°F	160	°C
Injection Molding		Value			
Drying Temperature		230	°F		
Drying Time		4.0 - 6.0	hrs		
Maximum Drying Time		8.0	hrs		
Suggested Maximum Moisture		0.02	%		
Suggested Shot Size		50 - 80	%		
Rear Barrel Temperatures		470 - 510	°F		
Middle Barrel Temperatures		480 - 520	°F		
Front Barrel Temperatures		490 - 530	°F		
Nozzle Temperature		490 - 520	°F		
Melt (processing) Temperatures		500 - 530	°F		
Mold Temperatures		150 - 190	°F		
Back Pressure		50 - 100	psi		
Screw speed		50 - 80	rpm		
Vent Depth		0.0050 - 0.0080	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.

EnCom Polymers, Inc.

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