

EnCounter 41512U

PC/Polyester



Product Description					
Impact Modified, PC/Polyester Blend, with UV Stability					
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	70	%	70	%
Flexural Modulus	ASTM D790	275,000	psi	1,897	MPa
Flexural Strength	ASTM D790	11,200	psi	77	MPa
Notched Izod Impact (73°F)	ASTM D256	12.0	ft-lb/in	641	J/m
Notched Izod Impact (-22°F)	ASTM D256	6.0	ft-lb/in	320	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.18	sp gr	1.18	sp gr
Melt Flow 260°C/5.0 kg	ASTM D1238	15.0	g/10min	15.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.016 - 0.018	in/in	0.016 - 0.018	mm/mm
Hardness Rockwell	ASTM D785	105		105	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	230	°F	110	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	200	°F	93	°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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