

# EnPure 0718U

PC



Product Description					
FDA Compliant Polycarbonate with UV Stabilizer					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Automotive, Business Equipment,				
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	115	%	115	%
Flexural Modulus	ASTM D790	335,000	psi	2,310	MPa
Flexural Strength	ASTM D790	12,000	psi	83	MPa
Notched Izod Impact (73°F)	ASTM D256	18.0	ft-lb/in	961	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.20	sp gr	1.20	sp gr
Melt Flow 300°C/1.2 kg	ASTM D1238	7.0	g/10min	7.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.006	in/in	0.006	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	279	°F	137	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	269	°F	132	°C
Injection Molding		Value			
Drying Temperature		220 - 250	°F		
Drying Time		4.00	hrs		
Maximum Drying Time		7.0	hrs		
Suggested Maximum Moisture		0.02	%		
Suggested Shot Size		40 - 75	%		
Rear Barrel Temperatures		520 - 560	°F		
Middle Barrel Temperatures		540 - 580	°F		
Front Barrel Temperatures		550 - 600	°F		
Nozzle Temperature		550 - 590	°F		
Melt (processing) Temperatures		560 - 600	°F		
Mold Temperatures		160 - 210	°F		
Back Pressure		50 - 100	psi		
Screw speed		30 - 70	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.