

EnPure 1812R

PC



Product Description					
High Flow PC with Mold Release					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Automotive, Business Equipment, Thin Walled Applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	8,500	psi	59	MPa
Tensile Elongation at Break	ASTM D638	120	%	120	%
Flexural Modulus	ASTM D790	330,000	psi	2,276	MPa
Flexural Strength	ASTM D790	11,500	psi	79	MPa
Notched Izod Impact (73°F)	ASTM D256	12.0	ft-lb/in	641	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	18.0	g/10min	18.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.006	in/in	0.152	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	270	°F	132	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	260	°F	127	°C
Injection Molding		Value			
Drying Temperature		220 - 250	°F		
Drying Time		4.0	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.