

Product Description					
UL94 5VA & V-0 20% Glass Filled, Flame Retardant, Polycarbonate w/ release					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Electrical / Electronic Applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	15,800	psi	109	MPa
Tensile Elongation at Break	ASTM D638	6	%	6	%
Flexural Modulus	ASTM D790	785,000	psi	5,414	MPa
Flexural Strength	ASTM D790	18,500	psi	128	MPa
Notched Izod Impact (73°F)	ASTM D256	3.0	ft-lb/in	160	J/m
CLTE	ASTM E831	1.80E-05	in/(in, °F)	3.24E-05	mm/(mm, °C)
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.35	sp gr	1.35	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.001-0.003	in/in	0.127 - 0.178	mm/mm
Filler Content		20.0	%	20.0	%
Flame Rating 0.125	UL 94	5VA		5VA	
Flame Rating 0.062	UL 94	V-0		V-0	
Water Absorption	ASTM D570	0.15	%	0.15	%
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	301	°F	149	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	296	°F	147	°C
Injection Molding		Value			
Drying Temperature	200 to 250 °F		°F		
Drying Time	4.0 hr		hrs		
Maximum Drying Time	7.0 hr		hrs		
Suggested Maximum Moisture	0.020%		%		
Suggested Shot Size	40 to 75 %		%		
Rear Barrel Temperatures	550 to 590 °F		°F		
Middle Barrel Temperatures	570 to 610 °F		°F		
Front Barrel Temperatures	590 to 630 °F		°F		
Nozzle Temperature	580 to 620 °F		°F		
Melt (processing) Temperatures	590 to 630 °F		°F		
Mold Temperatures	180 to 240 °F		°F		
Back Pressure	50 to 100 psi		psi		
Screw speed	25 to 75 rpm		rpm		
Vent Depth	0.0015 to 0.0030 inc		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.