

EnValoy 1012IM

PC/ABS



Product Description					
High Impact PC/ABS					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Automotive, Business Equipment, Thin Walled Applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	7,900	psi	54	MPa
Tensile Strength @ Break	ASTM D638	7,830	psi	54	MPa
Tensile Elongation at Break	ASTM D638	145	%	145	%
Flexural Modulus	ASTM D790	336,000	psi	2,317	MPa
Flexural Strength	ASTM D790	13,000	psi	90	MPa
Notched Izod Impact (73°F)	ASTM D256	12.0	ft-lb/in	641	J/m
Notched Izod Impact (-40°F)	ASTM D256	9.0	ft-lb/in	481	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.14	sp gr	1.14	sp gr
Melt Flow 260°C/5.0 kg	ASTM D1238	10.0	g/10min	10.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.007	in/in	0.178	mm/mm
Flame Rating 0.125	UL 94	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	255	°F	124	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	225	°F	107	°C
Injection Molding		Value			
Drying Temperature		180 - 220	°F		
Drying Time		2.0 - 4.0	hrs		
Maximum Drying Time		4.0	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		450 - 500	°F		
Middle Barrel Temperatures		455 - 505	°F		
Front Barrel Temperatures		465 - 525	°F		
Nozzle Temperature		475 - 525	°F		
Melt (processing) Temperatures		475 - 525	°F		
Mold Temperatures		175 - 200	°F		
Back Pressure		25 - 100	psi		
Screw speed		25 - 75	rpm		

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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