

EnValoy 1812

PC/ABS



Product Description					
Injection Grade PC/ABS					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Appliance, Tool and Equipment, Electrical Components				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	8,350	psi	58	MPa
Tensile Elongation at Break	ASTM D638	>140	%	>140	%
Flexural Modulus	ASTM D790	329,000	psi	2,269	MPa
Flexural Strength	ASTM D790	12,500	psi	86	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	1.13	sp gr	1.13	sp gr
Melt Flow 260°C/5.0 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 @ 264 psi	ASTM D648	230	°F	110	°C
Injection Molding		Value			
Drying Temperature	200 - 210 °F				
Drying Time	3.0 - 4.0 hrs				
Maximum Drying Time	4.0 hrs				
Suggested Maximum Moisture	0.02 %				
Rear Barrel Temperatures	480 - 520 °F				
Middle Barrel Temperatures	490 - 520 °F				
Front Barrel Temperatures	490 - 530 °F				
Nozzle Temperature	480 - 520 °F				
Melt (processing) Temperatures	480 - 520 °F				
Mold Temperatures	140 - 200 °F				
Back Pressure	25 - 100 psi				
Screw speed	25 - 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.

EnCom Polymers, Inc.

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