

EnValoy 1812U

PC/ABS



Product Description			
Injection Grade PC/ABS with UV Stabilizer			
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.