

EnValoy 204T

PC/ABS



Product Description					
Talc-filled PC/ABS, increased HDT, increased stiffness, Low CLTE with good aesthetics					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Automotive, Business Equipment				
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	>20%	%	>20%	%
Flexural Modulus	ASTM D790	573,000	psi	3,952	MPa
Flexural Strength	ASTM D790	13,800	psi	95	MPa
Notched Izod Impact (73°F)	ASTM D256	1.4	ft-lb/in	75	J/m
CLTE	ASTM E831	2.50E-10	in/(in, °F)	4.50E-10	mm/(mm, °C)
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.24	sp gr	1.24	sp gr
Melt Flow 260°C/5.0 kg	ASTM D1238	20.0	g/10min	20.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.004	in/in	0.102	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	240	°F	116	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	210	°F	99	°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		470 - 510	°F		
Front Barrel Temperatures		465 - 525	°F		
Nozzle Temperature		475 - 525	°F		
Melt (processing) Temperatures		475 - 525	°F		
Mold Temperatures		140 - 190	°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.

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