

EnValoy 2809

PC/ABS



| Product Description | | | | | |
|--|--|---------------|----------|---------------|---------|
| PC/ABS Alloy | | | | | |
| 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 | 8,560 | psi | 59 | MPa |
| Tensile Modulus | ASTM D638 | 290,000 | psi | 2000 | MPa |
| Tensile Elongation at Break | ASTM D638 | 100 | % | 100 | % |
| Flexural Modulus | ASTM D790 | 290,000 | psi | 2,000 | MPa |
| Flexural Strength | ASTM D790 | 10,700 | psi | 74 | MPa |
| Notched Izod Impact (73°F) | ASTM D256 | 9.2 | ft-lb/in | 491 | J/m |
| Physical Properties | Test Method | English Units | | S.I. Units | |
| Specific Gravity | ASTM D792 | 1.12 | sp gr | 1.12 | sp gr |
| Melt Flow 250°C/10 kg | ASTM D1238 | 28.0 | g/10min | 28.0 | g/10min |
| Mold Shrink - Flow: 0.126 in (3.20 mm) | ASTM D955 | 0.005 - 0.006 | in/in | 0.127 - 0.152 | mm/mm |
| Thermal Properties | Test Method | English Units | | S.I. Units | |
| Heat Deflection Temperature @ 66 psi | ASTM D648 | 253 | °F | 123 | °C |
| Heat Deflection Temperature @ 264 psi | ASTM D648 | 230 | °F | 110 | °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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