

EnValoy GEP1013

PC/ABS



Product Description					
Automotive PC/ABS Alloy					
General Properties					
Appearance	Black				
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 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	11.0	ft-lb/in	587	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 265°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	0.005 to 0.007	in/in	0.005 to 0.007	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	264	°F	129	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	234	°F	112	°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.

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