

# EnVelop 1812U-BK4068 (15 Melt)

PC/AES



Product Description					
UV Resistant PC/AES Alloy					
Automotive Specifications					
TSM5526G-1L					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Automotive Exterior & Interior, Consumer and General Industries				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	7,100	psi	49	MPa
Tensile Modulus	ASTM D638	274,000	psi	1890	MPa
Tensile Elongation at Break	ASTM D638	>60	%	>60	%
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	1.12	sp gr	1.12	sp gr
Melt Flow 220C/10kg	ASTM D1238	15.0	g/10min	15.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.006	in/in	0.006	mm/mm
Water Absorption	ASTM D570	0.25	%	0.25	%
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	205	°F	96	°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.

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