

EnCom C PC 1212 R

Polycarbonate

EnCom, Inc.

Message:

Low Friction, Molding Grade PC

General Information			
Features	Low Friction		
Uses	Automotive Applications		
	Business Equipment		
	Thin-walled Parts		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.50	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	58.6	MPa	ASTM D638
Flexural Modulus	2.38	MPa	ASTM D790
Flexural Strength (Yield)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	132	°C	
1.8 MPa, Unannealed	127	°C	
Flammability	Nominal Value		Test Method
Flame Rating (3.18 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	93.3 to 121	°C	

Drying Time	4.0	hr
Drying Time, Maximum	7.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 75	%
Rear Temperature	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	288 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.1 to 98.9	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 70	rpm
Vent Depth	0.038 to 0.076	mm

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