

EnCom FDA PC 1016

Polycarbonate

EnCom, Inc.

Message:

FDA PC

General Information			
Uses	Cups		
	Household Goods		
Agency Ratings	FDA Unspecified Rating		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength (Yield)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	850	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	135	°C	
1.8 MPa, Unannealed	129	°C	
Flammability	Nominal Value	Test Method	
Flame Rating (3.18 mm)	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	104 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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