

EnCom F5 PC 1013

Polycarbonate

EnCom, Inc.

Message:

UL94 5-VA approved FR PC

General Information			
Features	Flame Retardant		
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	1.20	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
Water Absorption (24 hr)	0.24	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	2240	MPa	ASTM D790
Flexural Strength (Yield)	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	670	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	138	°C	
1.8 MPa, Unannealed	133	°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+15	ohms · cm	ASTM D257

Dielectric Strength	26	kV/mm	ASTM D149
Dielectric Constant	3.15		ASTM D150
Dissipation Factor (1 MHz)	9.5E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.57 mm	V-0		
3.18 mm	5VA		
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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