

EnCom Branched PC 1006

Polycarbonate

EnCom, Inc.

Message:

FDA Approved Branched PC

General Information	
Uses	Industrial Applications
Agency Ratings	FDA Unspecified Rating
Appearance	Black
	Colors Available
	Natural Color
Forms	Pellets
Processing Method	Blow Molding
	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)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.60	%	ASTM D955
Water Absorption (24 hr)	0.070	%	ASTM D570

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	66.2	MPa	ASTM D638
Tensile Elongation (Break)	110	%	ASTM D638
Flexural Modulus	2370	MPa	ASTM D790
Flexural Strength (Yield)	98.3	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	910	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	145	°C	
1.8 MPa, Unannealed	139	°C	

Flammability	Nominal Value	Test Method
Flame Rating (3.18 mm)	HB	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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