

EnCom GF05 PC

Polycarbonate

EnCom, Inc.

Message:

5 % Glass Filled PC

General Information			
Filler / Reinforcement	Glass Fiber,5.0% Filler by Weight		
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	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	2380	MPa	ASTM D790
Flexural Strength (Yield)	124	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	210	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	128	°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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