

EnCom PC-ABS 1310

Polycarbonate + ABS

EnCom, Inc.

Message:

General Purpose PC/ABS Alloy

General Information			
Features	General Purpose		
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	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/5.0 kg)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	54.5	MPa	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus	2320	MPa	ASTM D790
Flexural Strength (Yield)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	120	°C	
1.8 MPa, Unannealed	110	°C	
Flammability	Nominal Value		Test Method
Flame Rating (3.18 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 104	°C	
Drying Time	2.0 to 4.0	hr	

Drying Time, Maximum	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	232 to 260	°C
Middle Temperature	235 to 263	°C
Front Temperature	241 to 274	°C
Nozzle Temperature	246 to 274	°C
Processing (Melt) Temp	246 to 274	°C
Mold Temperature	79.4 to 93.3	°C
Back Pressure	0.172 to 0.689	MPa
Screw Speed	25 to 75	rpm

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