

OmniCarb™ PC/PBT 1214

Polycarbonate + PBT

OMNI Plastics, LLC

Message:

PC/PBT Alloy

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage	0.50 to 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	58.6	MPa	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Flexural Strength	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	104	°C	
1.8 MPa, Unannealed, 3.18 mm	93.3	°C	
Flammability	Nominal Value		Test Method
Flame Rating (3.18 mm)	HB		Internal Method
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	249 to 271	°C	
Middle Temperature	249 to 282	°C	
Front Temperature	249 to 282	°C	
Nozzle Temperature	249 to 282	°C	
Processing (Melt) Temp	249 to 271	°C	
Mold Temperature	48.9 to 82.2	°C	
Back Pressure	0.345 to 0.689	MPa	

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