EnCom, Inc.
Engineering Compounding Specialists

Typical Properties
EnCom PC 1414
General Purpose PC

Property	Test Method	English Units		S.I. Units	
General					
Appearance		Black, Natural or Colors			
Processing Methods		Injection Molding, Profile Extrusion			
Applications		Automotive, Business Equipment, Thin Walled Applications			
Mechanical					
Tensile Strength	D 638	9,000	psi	62	Mpa
Elongation at Break	D 638	115	%	115	%
Flexural Modulus	D 790	330,000	psi	2,275	Mpa
Flexural Strength	D 790	12,000	psi	83	Mpa
Izod Impact, notched @ 73 F	D 256	14	ft-lb/in	745	J/m
Physical					
Specific Gravity, Solid (23C)	D 792	1.20	sp gr	1.20	sp gr
Mold Shrinkage, flow 0.125" (3.2mm)	D 955	0.006	in/in	0.006	mm/mm
Melt Flow : 300 °C/1.2 kg	D1238	14.0	g/10min	14.0	g/10min
Filler Content		0	%	0	%
Thermal					
Deflection Temperature, unannealed. 0.125" (3.2mm)	D 648				
66 psi (0.455 MPa), Load		270	°F	132	°C
264 psi (1.82 MPa), Load		260	°F	127	°C
UL Classification					
Rating @ Thickness	UL 94	E-V2	0.125 inch	E-V2	3.0 mm

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitablility.

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Processing Guidelines

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Drying Temperature	**220 to 250 °F**
Drying Time	**4.0 hr**
Maximum Drying Time	**7.0 hr**
Suggested Maximum Moisture	**0.020%**
Suggested Shot Size	**40 to 75 %**
Rear Barrel Temperatures	**520 to 560 °F**
Middle Barrel Temperatures	**540 to 580 °F**
Front Barrel Temperatures	**550 to 600 °F**
Nozzle Temperature	**550 to 590 °F**
Melt (processing) Temperatures	**560 to 600 °F**
Mold Temperatures	**160 to 210 °F**
Back Pressure	**50 to 100 psi**
Screw speed	**30 to 70 rpm**
Vent Depth	**0.0015 to 0.0030 inch**

The Conditions listed above are only guidelines. You should adjust conditions to meet your requirements.

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