



**OmniCarb™**  
**PC/PBT 1214 IM**  
 Impact Modified, PC/PBT

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min.	D1238	12	12
Specific Gravity		D792	1.21	1.21
Mold Shrinkage, Isotropic	in/in		.004 - .008	

**IMPACT**

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	14	747
--	-------------------	------	----	-----

**MECHANICAL**

Tensile Strength At Yield, 73°F	psi (MPa)	D638	9,000	62
Tensile Elongation	%	D638	120	120
Flexural Modulus	psi (MPa)	D790	360,000	2,482
Flexural Strength	psi (MPa)	D790	12,800	88

**THERMAL**

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	220	104
1/8" bar, 264 psi	°F (°C)	D648	200	93

**FLAMMABILITY**

Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
--	-------	------	-----	-----

**RECOMMENDED PROCESSING CONDITIONS**

Drying Temperature	230 °F
Drying Time	2-4 hrs. max.
Maximum Moisture	0.02%
Rear Zone(s)	480 to 520° F
Middle Zone(s)	480 to 540° F
Front Zone(s)	480 to 540° F
Nozzle	480 to 540° F
Mold Temperature	120 to 180° F
Melt Temperature	480 to 520° F
Back Pressure	50 to 100 psi

Values are based on natural or black materials unless otherwise noted. Properties and values herein are based on laboratory test specimens and should not be used to establish minimum specification limits or fabricate tooling.

Omni does not guarantee the accuracy of this information or the suitability of this product in any given application or usage situation.