



OmniCarb™
PC/PBT 1214
 General Purpose, PC/PBT

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min.	D1238	14	14
Specific Gravity		D792	1.21	1.21
Mold Shrinkage	in/in		.005 - .009	

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	12	640
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MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	8,500	59
Tensile Elongation	%	D638	120	120
Flexural Modulus	psi (MPa)	D790	310,000	2,137
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*
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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.