



**OmniCarb™**  
**PC/PBT 400IM2**

Cold Temperature Impact Resistant, UV Stabilized, PC/PBT

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min.	D1238	12	12
Specific Gravity		D792	1.18	1.18
Mold Shrinkage, Isotropic	in/in		.005 - .011	

**IMPACT**

Izod Impact Resistance				
Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	14	747
Notched 1/8" bar, -22°F	ft.-lbs/in. (J/m)	D256	12	641

**MECHANICAL**

Tensile Strength				
At Yield, 73°F	psi (MPa)	D638	7,500	52
Tensile Elongation	%	D638	120	120
Flexural Modulus	psi (MPa)	D790	280,000	1,931
Flexural Strength	psi (MPa)	D790	12,000	83

**THERMAL**

Deflection Temperature				
1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	205	96

**FLAMMABILITY**

**UL File Number E138590**

Flame Resistance	.118" (3mm)	UL94	HB*	HB*
Flame Resistance	.059" (1.5mm)	UL94	HB*	HB*

\* Black Color Only

**RECOMMENDED PROCESSING CONDITIONS**

Drying Temperature	220 to 240 °F
Drying Time	2-4 hrs. max.
Maximum Moisture	0.02%
Rear Zone(s)	440 to 470° F
Middle Zone(s)	450 to 480° F
Front Zone(s)	460 to 500° F
Nozzle	460 to 500° F
Mold Temperature	120 to 180° F
Melt Temperature	460 to 500° 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.