



ColorFast® PCT4000CL

PRODUCT DESCRIPTION Amorphous copolyester with excellent appearance, clarity and improved chemical resistance

MATERIAL STATUS Commercial: Active

AVAILABILITY Africa & Middle East, Asia Pacific, Europe, Latin America, North America

FEATURES Excellent Colorability

USES Automotive Applications, Consumer Applications, Engineering Parts, Household Goods, Housings, Industrial Applications, Industrial Parts

FORMS Pellets

PROCESSING METHOD Injection Molding

PHYSICAL	NOMINAL VALUE	UNIT	TEST METHOD
Density / Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/3.8 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	ASTM D955
MECHANICAL	NOMINAL VALUE	UNIT	TEST METHOD
Tensile Strength ²			ASTM D638
Yield	43.0	MPa	
Break	53.0	MPa	
Tensile Elongation ²			ASTM D638
Yield	6.0	%	
Break	210	%	
Flexural Modulus ²	1550	MPa	ASTM D790
Flexural Strength ²	62.0	MPa	ASTM D790
IMPACT	NOMINAL VALUE	UNIT	TEST METHOD
Notched Izod Impact (23°C)	960	J/m	ASTM D256
HARDNESS	NOMINAL VALUE	UNIT	TEST METHOD
Rockwell Hardness (M-Scale)	112		ASTM D785
THERMAL	NOMINAL VALUE	UNIT	TEST METHOD
Deflection Temperature Under Load 1.8 MPa, Unannealed, 3.20 mm	85.0	°C	ASTM D648
FLAMMABILITY	NOMINAL VALUE	UNIT	TEST METHOD
Flame Rating (1.5 mm, all color)	HB		UL 94



INJECTION	NOMINAL VALUE	UNIT
Drying Temperature	88	°C
Drying Time	4.0 to 6.0	hr
Suggested Shot Size	40 to 80	%
Rear Temperature	243 to 266	°C
Middle Temperature	249 to 271	°C
Front Temperature	254 to 277	°C
Nozzle Temperature	254 to 271	°C
Processing (Melt) Temp	260 to 282	°C
Mold Temperature	38 to 66	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	50 to 80	rpm
Vent Depth	0.013 to 0.020	mm

NOTES

¹ Typical properties: these are not to be construed as specifications.

² 51 mm/min

