

**ColorFast® PC101IR**

Americhem - Polycarbonate

**General Information**
**Product Description**

10 melt injection molding grade polycarbonate with excellent low-temperature impact, mold release and improved hydrolytic stability compared to regular PC

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Additive	• Impact Modifier
Features	• Excellent Colorability • High Impact Resistance • Low Temperature Impact Resistance • Low Temperature Toughness
Uses	• Automotive Applications • Closures • Consumer Applications • Engineering Parts • Household Goods • Housings • Industrial Applications • Industrial Parts • Office Automation Equipment
UL File Number	• E178307
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	8000	psi	ASTM D638
Tensile Strength <sup>2</sup> (Break)	9000	psi	ASTM D638
Tensile Elongation <sup>2</sup> (Yield)	7.0	%	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	130	%	ASTM D638
Flexural Modulus <sup>2</sup>	300000	psi	ASTM D790
Flexural Strength <sup>2</sup>	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	15	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	270	°F	ASTM D648

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	520 to 560	°F
Middle Temperature	540 to 580	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	560 to 600	°F
Mold Temperature	160 to 200	°F

