

**ColorFast® PC250UR**

Americhem - Polycarbonate

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

PC250UR is a high flow injection molding grade of optical grade polycarbonate (PC) with mold release and UV. It is suitable for a wide range of applications including lenses and lighting products.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Mold Release • UV Stabilizer		
Features	• Excellent Colorability • Lubricated • Good Mold Release • UV Stabilized		
Uses	• Automotive Applications • Closures • Consumer Applications • Engineering Parts	• Household Goods • Housings • Industrial Applications • Industrial Parts	• Office Automation Equipment • Outdoor Applications
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)	25	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)	8950	psi	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	110	%	ASTM D638
Flexural Modulus <sup>2</sup>	334000	psi	ASTM D790
Flexural Strength <sup>2</sup>	13500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	259	°F	ASTM D648

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	248	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 520	°F
Middle Temperature	500 to 535	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	510 to 560	°F
Processing (Melt) Temp	520 to 565	°F
Mold Temperature	160 to 200	°F
Back Pressure	45.0 to 100	psi
Screw Speed	40 to 70	rpm

