ColorFast® PC200R

Americhem - *Polycarbonate*

General Information

Product Description			
20 melt superior processing, fast cycling Polycarbonate with release			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Mold Release		
Features	• Excellent Colorability	• Good Mold Release	• Lubricated
Uses	• Automotive Applications • Closures • Consumer Applications	• Engineering Parts • Household Goods • Housings	• Industrial Applications • Industrial Parts • Office Automation Equipment
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	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 [2] (Yield)	9400	psi	ASTM D638
Tensile Strength [2] (Break)	10200	psi	ASTM D638
Tensile Elongation [2] (Yield)	6.0	%	ASTM D638
Tensile Elongation [2] (Break)	120	%	ASTM D638
Flexural Modulus [2]	340000	psi	ASTM D790
Flexural Strength [2]	14000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	14	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)	260	°F	ASTM D648

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	48	hr
Suggested Shot Size	40 to 60	%
Rear Temperature	480 to 520	°F
Middle Temperature	500 to 540	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	510 to 555	°F
Processing (Melt) Temp	520 to 560	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 200	psi

Screw Speed	40 to 70 rpm
Vent Depth	1.0E-3 to 3.0E-3 in

Notes

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

[2] 2.0 in/min