

ColorFast® SFT3000HF

Americhem - Polycarbonate

General Information
Product Description

SFT3000HF is a standard flow injection molding grade of polycarbonate alloy with good heat resistance. It is suitable for Aerospace applications meeting FAA flammability requirements for FAR 25.853(d) and OSU heat release = 65/65. Available in natural and opaque colors.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Features	• Excellent Colorability • High Flow
Uses	• Aerospace Applications • Engineering Parts • Industrial Parts • Automotive Applications • Household Goods • Office Automation Equipment • Closures • Housings • Consumer Applications • Industrial Applications
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	8400	psi	ASTM D638
Tensile Strength ² (Break)	7200	psi	ASTM D638
Tensile Elongation ² (Yield)	6.0	%	ASTM D638
Tensile Elongation ² (Break)	70	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	8.0	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
OSU Peak Heat Release Rate - 5 minute test (78.7 mil)	< 65.0	kW/m ²	FAR 25.853(d)
OSU Total Heat Release - 2 minute test (78.7 mil)	< 65.0	kW·min/m ²	FAR 25.853(d)
Smoke Density	< 200		FAR 25.853(d)

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Drying Time, Maximum	24	hr
Suggested Shot Size	40 to 60	%
Rear Temperature	520 to 560	°F
Middle Temperature	530 to 570	°F
Front Temperature	550 to 590	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	550 to 590	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	1.0E-3 to 3.0E-3	in

