

**ColorFast® PCC-1410**

Americhem - Polycarbonate

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

11 melt UV-stabilized, UV-stabilized injection molding grade Polycarbonate/Siloxane Copolymer, with good low temperature impact and ductility.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Good Scratch Resistance	• Low Temperature Impact Resistance	• UV Stabilized
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	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)	8200	psi	ASTM D638
Tensile Elongation <sup>2</sup> (Yield)	110	%	ASTM D638
Flexural Modulus <sup>2</sup>	275000	psi	ASTM D790
Flexural Strength <sup>2</sup>	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-22°F	11	ft·lb/in	
73°F	13	ft·lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	255	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

**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	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
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	1.0E-3 to 3.0E-3	in

