

ColorFast® PCC-841T

Americhem - Polycarbonate

General Information

Product Description

11 melt injection molding grade transparent Polycarbonate/Siloxane Copolymer, with good low temperature impact and ductility, for food contact applications.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Food Contact Acceptable	• Good Scratch Resistance	• Low Temperature Impact Resistance
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)	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 ² (Yield)	8900	psi	ASTM D638
Tensile Elongation ² (Yield)	6.0	%	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ²	300000	psi	ASTM D790
Flexural Strength ²	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-22°F	13	ft·lb/in	
73°F	15	ft·lb/in	
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)	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

Notes

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

² 2.0 in/min

