

ColorFast® PAHF

Americhem - Polycarbonate + ABS

General Information
Product Description

General purpose HB-rated PC/ABS with improved chemical resistance

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.15		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 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)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	8300	psi	ASTM D638
Tensile Strength ² (Break)	7300	psi	ASTM D638
Tensile Elongation ² (Yield)	5.0	%	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ²	340000	psi	ASTM D790
Flexural Strength ²	12800	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, 0.126 in)	225	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	3.0 to 4.0	hr
Suggested Shot Size	30 to 80	%
Rear Temperature	480 to 540	°F
Middle Temperature	490 to 550	°F
Front Temperature	550 to 565	°F
Nozzle Temperature	515 to 555	°F
Processing (Melt) Temp	505 to 565	°F
Mold Temperature	140 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

