ColorFast® PAHF-UV1
Americhem - *Polycarbonate + ABS*

General Information

Product Description

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

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• UV Stabilizer		
Features	• Excellent Colorability	• High Flow	• UV Stabilized
Uses	• Automotive Applications • Closures • Consumer Applications • Engineering Parts	• Household Goods • Housings • Industrial Applications • Industrial Parts	• Office Automation Equipment • Outdoor Applications
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)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955

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)	100	%	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)	220	°F	ASTM D648

Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220 to 230	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	30 to 80	%
Rear Temperature	480 to 550	°F
Middle Temperature	490 to 560	°F
Front Temperature	500 to 575	°F
Nozzle Temperature	525 to 575	°F
Processing (Melt) Temp	525 to 575	°F
Mold Temperature	140 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

Vent Depth	1.5E-3 to 3.0E-3 in