

ColorFast® PCT1018
Americhem - Polycarbonate + PET
General Information
Product Description

PC/PET alloy with good balance of physical properties

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Excellent Colorability		
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	1.16		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/3.8 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	7500	psi	ASTM D638
Tensile Elongation ² (Break)	100	%	ASTM D638
Flexural Modulus ²	280000	psi	ASTM D790
Flexural Strength ²	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	15	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	40 to 80	%
Rear Temperature	450 to 510	°F
Middle Temperature	450 to 520	°F
Front Temperature	460 to 530	°F
Nozzle Temperature	460 to 500	°F
Processing (Melt) Temp	480 to 530	°F
Mold Temperature	150 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 80	rpm
Vent Depth	5.0E-4 to 8.0E-4	in

