

ColorFast® PCT2300

Americhem - Polycarbonate + PBT

General Information

Product Description

Unfilled PBT + PC alloy, Outstanding low temperature impact

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	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/3.8 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.010 to 0.012	in/in	ASTM D955
Water Absorption (24 hr)	0.080	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6800	psi	ASTM D638
Tensile Strength ² (Break)	7000	psi	ASTM D638
Tensile Elongation (Yield)	4.0	%	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ²	240000	psi	ASTM D790
Flexural Strength ²	10000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	13	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220	°F
Drying Time	4.0 to 6.0	hr
Suggested Shot Size	40 to 60	%
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	500 to 530	°F
Mold Temperature	150 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 150	rpm
Vent Depth	5.0E-3 to 8.0E-3	in

