

ColorFast® PCT2018

Americhem - Polycarbonate + PBT

General Information

Product Description

PC/PBT alloy with excellent low temperature impact strength

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/3.8 kg)	10	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)	6600	psi	ASTM D638
Tensile Strength ² (Break)	5600	psi	ASTM D638
Tensile Elongation ² (Break)	140	%	ASTM D638
Flexural Modulus ²	270000	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	200	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	40 to 80	%
Rear Temperature	470 to 510	°F
Middle Temperature	480 to 520	°F
Front Temperature	490 to 530	°F
Nozzle Temperature	490 to 500	°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 80	rpm
Vent Depth	5.0E-4 to 8.0E-4	in

