

ColorFast® PCT2011

Americhem - Polycarbonate + PBT

General Information
Product Description

impact modified PC/PBT alloy, 10% glass fiber reinforced, improved impact strength and ductility

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	1.30		ASTM D792
Molding Shrinkage - Flow	7.0E-3 to 9.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.11	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	8990	psi	ASTM D638
Tensile Strength ² (Break)	8990	psi	ASTM D638
Tensile Elongation ² (Break)	4.0	%	ASTM D638
Flexural Modulus ²	399000	psi	ASTM D790
Flexural Strength ²	13900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	3.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness	113		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	250	°F	ASTM D648

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	460 to 530	°F
Middle Temperature	470 to 540	°F
Front Temperature	480 to 540	°F
Nozzle Temperature	490 to 550	°F
Processing (Melt) Temp	500 to 560	°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

