

ColorFast® PBA1000

Americhem - Acrylonitrile Butadiene Styrene + PBT

General Information

Product Description

PBT/ABS alloy with excellent physical properties and chemical resistance

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6800	psi	ASTM D638
Tensile Strength ² (Break)	4800	psi	ASTM D638
Tensile Elongation ² (Yield)	7.0	%	ASTM D638
Tensile Elongation ² (Break)	35	%	ASTM D638
Flexural Modulus ²	300000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.6	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	40 to 60	%
Rear Temperature	400 to 460	°F
Middle Temperature	410 to 450	°F
Front Temperature	430 to 490	°F
Nozzle Temperature	420 to 480	°F
Processing (Melt) Temp	430 to 490	°F
Mold Temperature	50 to 160	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	1.0E-3 to 3.0E-3	in

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

