

ColorFast® PBA1000

Acrylonitrile Butadiene Styrene + PBT

LTL Color Compounders, Inc.

Message:

PBT/ABS alloy with excellent physical properties and chemical resistance

General Information			
Features	Good Chemical Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	46.9	MPa	
Break	33.1	MPa	
Tensile Elongation ²			ASTM D638
Yield	7.0	%	
Break	35	%	
Flexural Modulus ³	2070	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	85	J/m	ASTM D256
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	40 to 60	%	
Rear Temperature	204 to 238	°C	
Middle Temperature	210 to 232	°C	
Front Temperature	221 to 254	°C	
Nozzle Temperature	216 to 249	°C	
Processing (Melt) Temp	221 to 254	°C	
Mold Temperature	10.0 to 71.1	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	51 mm/min		
2.	51 mm/min		
3.	51 mm/min		

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