

ColorFast® PAHF

Polycarbonate + ABS

LTL Color Compounders, Inc.

Message:

General purpose HB-rated PC/ABS with improved chemical resistance

General Information			
Features	General Purpose		
	Good Chemical Resistance		
Uses	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	57.2	MPa	
Break	50.3	MPa	
Tensile Elongation ²			ASTM D638
Yield	5.0	%	
Break	100	%	
Flexural Modulus ³	2340	MPa	ASTM D790
Flexural Strength ⁴	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	104	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	104 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	30 to 80	%	
Rear Temperature	249 to 288	°C	
Middle Temperature	254 to 293	°C	

Front Temperature	260 to 302	°C
Nozzle Temperature	274 to 302	°C
Processing (Melt) Temp	274 to 302	°C
Mold Temperature	60.0 to 87.8	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm

NOTE

- | | |
|----|-----------|
| 1. | 51 mm/min |
| 2. | 51 mm/min |
| 3. | 51 mm/min |
| 4. | 51 mm/min |

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