

# ColorFast® PC200

Polycarbonate  
LTL Color Compounders, Inc.

Message:  
20 melt superior processing, fast cycling

| General Information                                              |                     |                   |             |
|------------------------------------------------------------------|---------------------|-------------------|-------------|
| Features                                                         | Fast Molding Cycle  |                   |             |
|                                                                  | Good Processability |                   |             |
| Forms                                                            | Pellets             |                   |             |
| Processing Method                                                | Injection Molding   |                   |             |
| Physical                                                         | Nominal Value       | Unit              | Test Method |
| Specific Gravity                                                 | 1.20                | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)                         | 20                  | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow (3.18 mm)                               | 0.50 to 0.70        | %                 | ASTM D955   |
| Hardness                                                         | Nominal Value       | Unit              | Test Method |
| Rockwell Hardness (M-Scale)                                      | 70                  |                   | ASTM D785   |
| Mechanical                                                       | Nominal Value       | Unit              | Test Method |
| Tensile Strength <sup>1</sup>                                    |                     |                   | ASTM D638   |
| Yield                                                            | 62.1                | MPa               |             |
| Break                                                            | 65.5                | MPa               |             |
| Tensile Elongation <sup>2</sup>                                  |                     |                   | ASTM D638   |
| Yield                                                            | 6.0                 | %                 |             |
| Break                                                            | 120                 | %                 |             |
| Flexural Modulus <sup>3</sup>                                    | 2310                | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup>                                   | 93.1                | 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) | 127                 | °C                | ASTM D648   |
| Injection                                                        | Nominal Value       | Unit              |             |
| Drying Temperature                                               | 121                 | °C                |             |
| Drying Time                                                      | 3.0 to 4.0          | hr                |             |
| Drying Time, Maximum                                             | 48                  | hr                |             |
| Suggested Shot Size                                              | 40 to 60            | %                 |             |
| Rear Temperature                                                 | 249 to 271          | °C                |             |
| Middle Temperature                                               | 260 to 282          | °C                |             |
| Front Temperature                                                | 271 to 293          | °C                |             |

|                        |                |     |
|------------------------|----------------|-----|
| Nozzle Temperature     | 266 to 288     | °C  |
| Processing (Melt) Temp | 271 to 293     | °C  |
| Mold Temperature       | 71.1 to 93.3   | °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 |
| 4. | 51 mm/min |

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