

ColorFast® PC60

Polycarbonate

LTL Color Compounders, Inc.

Message:

6 melt extrusion grade

General Information			
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.0	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 ¹			ASTM D638
Yield	62.1	MPa	
Break	68.9	MPa	
Tensile Elongation ²			ASTM D638
Yield	7.0	%	
Break	140	%	
Flexural Modulus ³	2340	MPa	ASTM D790
Flexural Strength ⁴	97.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	910	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	132	°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	288 to 310	°C	
Middle Temperature	299 to 321	°C	
Front Temperature	310 to 332	°C	
Nozzle Temperature	304 to 327	°C	

Processing (Melt) Temp	310 to 332	°C
Mold Temperature	82.2 to 116	°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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