

ColorFast® ACR100

Polymethyl Methacrylate Acrylic

LTL Color Compounders, Inc.

Message:

High heat injection molding grade of PMMA

General Information			
Features	High Heat Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.7	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	93		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	68.9	MPa	ASTM D638
Tensile Elongation ² (Break)	6.0	%	ASTM D638
Flexural Modulus ³	3100	MPa	ASTM D790
Flexural Strength ⁴	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	21	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	102	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Shot Size	40 to 60	%	
Rear Temperature	210 to 232	°C	
Middle Temperature	216 to 238	°C	
Front Temperature	221 to 243	°C	
Nozzle Temperature	216 to 238	°C	
Processing (Melt) Temp	221 to 243	°C	
Mold Temperature	65.6 to 87.8	°C	
Back Pressure	0.689 to 1.38	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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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