

ColorFast® FRPC800

Polycarbonate

LTL Color Compounders, Inc.

Message:

Non-chlorinated, non-brominated, flame retarded V-0 Polycarbonate, available in opaque colors

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
Appearance	Colors Available Opaque		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60 to 0.80	%	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	61.4	MPa	
Break	65.5	MPa	
Tensile Elongation ²			ASTM D638
Yield	6.0	%	
Break	100	%	
Flexural Modulus ³	2280	MPa	ASTM D790
Flexural Strength ⁴	89.6	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)	132	°C	ASTM D648

Flammability	Nominal Value	Test Method
Flame Rating (1.10 mm)	V-0	UL 94

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	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	293 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°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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