

ColorFast® FRPC310

Polycarbonate

LTL Color Compounders, Inc.

Message:

V0-rated 10% glass-filled polycarbonate, excellent impact strength

General Information			
UL YellowCard	E178307-226558		
Filler / Reinforcement	Glass Fiber, 10% Filler by Weight		
Features	Flame Retardant		
	High Impact Resistance		
UL File Number	E178307		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	66.2	MPa	
Break	55.2	MPa	
Tensile Elongation ²			ASTM D638
Yield	8.0	%	
Break	15	%	
Flexural Modulus ³	3450	MPa	ASTM D790
Flexural Strength ⁴	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	142	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
3.00 mm	5VA		
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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