

## LTL Color Compounds ColorFast<sup>®</sup> ACR100 Polymethylmethacrylate

Category : Polymer , Thermoplastic , Acrylic (PMMA)

### Material Notes:

High heat injection molding grade of PMMA All information provided by LTL Color Compounders, Inc.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_LTL-Color-Compounds-ColorFast-ACR100-Polymethylmethacrylate.php](http://www.lookpolymers.com/polymer_LTL-Color-Compounds-ColorFast-ACR100-Polymethylmethacrylate.php)

Physical Properties	Metric	English	Comments
Specific Gravity	1.19 g/cc	1.19 g/cc	ASTM D792
Linear Mold Shrinkage	0.0020 - 0.0060 cm/cm	0.0020 - 0.0060 in/in	0.125; ASTM D955
Melt Flow	3.7 g/10 min @Load 3.80 kg, Temperature 230 °C	3.7 g/10 min @Load 8.38 lb, Temperature 446 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell M	93	93	ASTM D785
Tensile Strength, Yield	68.9 MPa	10000 psi	2.0 in/min; ASTM D638
Elongation at Break	6.0 %	6.0 %	2.0 in/min; ASTM D638
Flexural Strength	103 MPa	15000 psi	2.0 in/min; ASTM D790
Flexural Modulus	3.10 GPa	450 ksi	2.0 in/min; ASTM D790
Izod Impact, Notched	0.214 J/cm @Temperature 22.8 °C	0.400 ft-lb/in @Temperature 73.0 °F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	102 °C	216 °F	Unannealed (0.250"); ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	210 - 232 °C	410 - 450 °F	
Middle Barrel Temperature	216 - 238 °C	420 - 460 °F	
Front Barrel Temperature	221 - 243 °C	430 - 470 °F	
Nozzle Temperature	216 - 238 °C	420 - 460 °F	
Melt Temperature	221 - 243 °C	430 - 470 °F	

Processing Properties	Metric	English	Comments
Drying Temperature	82.2 °C	180 °F	
Dry Time	3 - 4 hour	3 - 4 hour	nominal; maximum drying time of 48 hours
Back Pressure	0.689 - 1.38 MPa	100 - 200 psi	
Shot Size	40 - 60 %	40 - 60 %	
Vent Depth	0.00254 - 0.00762 cm	0.00100 - 0.00300 in	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

## Contact Songhan Plastic Technology Co.,Ltd.

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