

LTL Color Compounds ColorFast® PAHF Polycarbonate-ABS Alloy

Category : Polymer , Thermoplastic , ABS Polymer , Polycarbonate/ABS Alloy, Unreinforced , Polycarbonate (PC)

Material Notes:

General purpose HB-rated PC/ABS with improved chemical resistance All information provided by LTL Color Compounders, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_LTL-Color-Compounds-ColorFast-PAHF-Polycarbonate-ABS-Alloy.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.15 g/cc	1.15 g/cc	ASTM D792
Linear Mold Shrinkage	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	0.125; ASTM D955
Melt Flow	19 g/10 min @Load 5.00 kg, Temperature 260 °C	19 g/10 min @Load 11.0 lb, Temperature 500 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	50.3 MPa	7300 psi	2.0 in/min; ASTM D638
Tensile Strength, Yield	57.2 MPa	8300 psi	2.0 in/min; ASTM D638
Elongation at Break	100 %	100 %	2.0 in/min; ASTM D638
Elongation at Yield	5.0 %	5.0 %	2.0 in/min; ASTM D638
Flexural Strength	88.3 MPa	12800 psi	2.0 in/min; ASTM D790
Flexural Modulus	2.34 GPa	340 ksi	2.0 in/min; ASTM D790
Izod Impact, Notched	6.41 J/cm @Temperature 22.8 °C	12.0 ft-lb/in @Temperature 73.0 °F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	104 °C	220 °F	Unannealed (0.250"); ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	249 - 288 °C	480 - 550 °F	
Middle Barrel Temperature	254 - 293 °C	490 - 560 °F	
Front Barrel Temperature	260 - 302 °C	500 - 575 °F	
Nozzle Temperature	274 - 302 °C	525 - 575 °F	

Processing Properties	Metric102 Â°C	English75 Â°F	Comments
Mold Temperature	60.0 - 87.8 Â°C	140 - 190 Â°F	
Drying Temperature	104 - 110 Â°C	220 - 230 Â°F	
Dry Time	3 - 4 hour	3 - 4 hour	nominal; maximum drying time of 8 hours
Back Pressure	0.345 - 0.689 MPa	50.0 - 100 psi	
Shot Size	30 - 80 %	30 - 80 %	
Vent Depth	0.00381 - 0.00762 cm	0.00150 - 0.00300 in	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

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