

ColorFast® ACR100IM

Polymethyl Methacrylate Acrylic

LTL Color Compounders, Inc.

Message:

High impact version, extrusion or injection molding PMMA

General Information			
Features	High Impact Resistance		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.0	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)	45		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	37.9	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield	5.0	%	
Break	35	%	
Flexural Modulus ³	1860	MPa	ASTM D790
Flexural Strength ⁴	68.9	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	59	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	79.4	°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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