

# ColorFast® PC150

Polycarbonate

LTL Color Compounders, Inc.

## Message:

15 melt high flow polycarbonate

General Information			
Features	High Flow		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>			ASTM D638
Yield	62.1	MPa	
Break	68.9	MPa	
Tensile Elongation <sup>2</sup>			ASTM D638
Yield	7.0	%	
Break	130	%	
Flexural Modulus <sup>3</sup>	2340	MPa	ASTM D790
Flexural Strength <sup>4</sup>	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	129	°C	ASTM D648
Injection	Nominal Value	Unit	Test Method
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	260 to 282	°C	
Middle Temperature	271 to 293	°C	
Front Temperature	282 to 304	°C	
Nozzle Temperature	277 to 299	°C	
Processing (Melt) Temp	282 to 304	°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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### Recommended distributors for this material

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