

ColorFast® JCT1000

Polycarbonate + ABS + SMA

LTL Color Compounders, Inc.

Message:

Unique PC/ABS/SMA alloy with improved processing and reduced plate-out

General Information			
Features	Good Processability		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.40 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	60.0	MPa	
Break	55.8	MPa	
Tensile Elongation ²			ASTM D638
Yield	4.0	%	
Break	90	%	
Flexural Modulus ³	2700	MPa	ASTM D790
Flexural Strength ⁴	95.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	95.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	30 to 60	%	
Rear Temperature	210 to 254	°C	
Middle Temperature	216 to 260	°C	
Front Temperature	227 to 274	°C	
Nozzle Temperature	232 to 274	°C	
Processing (Melt) Temp	232 to 274	°C	

Mold Temperature	60.0 to 82.2	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 75	rpm
Vent Depth	0.038 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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