

ColorFast® ACR100

PMMA

Americhem Engineered Compounds

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	3.7	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	68.9	MPa	ASTM D 638
Elongation at Break	6	%	ASTM D 638
Flexural Modulus	3103	MPa	ASTM D 790
Flexural Strength	103	MPa	ASTM D 790
Rockwell Hardness	M93	-	ASTM D 785
Izod Impact notched, 1/8 in	21.4	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	102	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1190	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	82.2	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	221 - 243	°C	-
Mold temperature	65.6 - 87.8	°C	-
Zone 1	210 - 232	°C	-
Zone 2	216 - 238	°C	-
Zone 3	221 - 243	°C	-
Nozzle temperature	216 - 238	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.689 - 1.38	MPa	-

Characteristics**Processing**

Injection Molding

Features

Low Odor

Delivery form

Pellets

Regional Availability

North America

Special Characteristics

Heat stabilized or stable to heat