

LTL Color Compounds ColorFast® FRA204 ABS

Category : Polymer , Thermoplastic , ABS Polymer

Material Notes:

High gloss, excellent impact ABS, V0/5VA-rated All information provided by LTL Color Compounds, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_LTL-Color-Compounds-ColorFast-FRA204-ABS.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.25 g/cc	1.25 g/cc	ASTM D792
Linear Mold Shrinkage	0.0030 - 0.0060 cm/cm	0.0030 - 0.0060 in/in	0.125; ASTM D955
Melt Flow	8.0 g/10 min @Load 3.80 kg, Temperature 230 Â°C	8.0 g/10 min @Load 8.38 lb, Temperature 446 Â°F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	95	95	ASTM D785
Tensile Strength, Yield	41.4 MPa	6000 psi	2.0 in/min; ASTM D638
Elongation at Break	10 %	10 %	2.0 in/min; ASTM D638
Flexural Strength	61.4 MPa	8900 psi	2.0 in/min; ASTM D790
Flexural Modulus	2.28 GPa	330 ksi	2.0 in/min; ASTM D790
Izod Impact, Notched	2.67 J/cm @Temperature 22.8 Â°C	5.00 ft-lb/in @Temperature 73.0 Â°F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	73.9 Â°C	165 Â°F	Unannealed (0.250"); ASTM D648
Flammability, UL94	V-0 @Thickness 1.50 mm	V-0 @Thickness 0.0591 in	
	5VA @Thickness 2.60 mm	5VA @Thickness 0.102 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	171 - 182 Â°C	340 - 360 Â°F	

Middle Barrel Temperature Processing Properties	199 - 210 Â°C Metric	390 - 410 Â°F English	Comments
Front Barrel Temperature	210 - 221 Â°C	410 - 430 Â°F	
Nozzle Temperature	193 - 221 Â°C	380 - 430 Â°F	
Melt Temperature	193 - 232 Â°C	380 - 450 Â°F	
Mold Temperature	71.1 - 82.2 Â°C	160 - 180 Â°F	
Drying Temperature	71.1 - 82.2 Â°C	160 - 180 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	50 - 70 %	50 - 70 %	
Vent Depth	0.00381 - 0.00508 cm	0.00150 - 0.00200 in	
Screw Speed	30 - 60 rpm	30 - 60 rpm	

Descriptive Properties	Value	Comments
UL File Number	E178307	

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