

ColorFast® GPA300X

Acrylonitrile Butadiene Styrene

LTL Color Compounders, Inc.

Message:

Extrusion grade, high impact, high gloss ABS

General Information			
Features	High Gloss		
	High Impact Resistance		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	35.9	MPa	
Break	27.6	MPa	
Tensile Elongation ²			ASTM D638
Yield	3.0	%	
Break	110	%	
Flexural Modulus ³	1720	MPa	ASTM D790
Flexural Strength ⁴	51.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	82.8	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	30 to 60	%	
Rear Temperature	188 to 210	°C	

Middle Temperature	204 to 227	°C
Front Temperature	216 to 238	°C
Nozzle Temperature	218 to 260	°C
Processing (Melt) Temp	218 to 260	°C
Mold Temperature	48.9 to 71.1	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm
Vent Depth	0.038 to 0.051	mm

NOTE

- | | |
|----|-----------|
| 1. | 51 mm/min |
| 2. | 51 mm/min |
| 3. | 51 mm/min |
| 4. | 51 mm/min |

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