

ColorFast® FRA204

Acrylonitrile Butadiene Styrene

LTL Color Compounders, Inc.

Message:

High gloss, excellent impact ABS, V0/5VA-rated

General Information			
UL YellowCard	E178307-226548		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Impact Resistance		
	High Gloss		
UL File Number	E178307		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	41.4	MPa	ASTM D638
Tensile Elongation ² (Break)	10	%	ASTM D638
Flexural Modulus ³	2280	MPa	ASTM D790
Flexural Strength ⁴	61.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	73.9	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
2.60 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	

Suggested Shot Size	50 to 70	%
Rear Temperature	171 to 182	°C
Middle Temperature	199 to 210	°C
Front Temperature	210 to 221	°C
Nozzle Temperature	193 to 221	°C
Processing (Melt) Temp	193 to 232	°C
Mold Temperature	71.1 to 82.2	°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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