

ColorFast® FRA202

Americhem - Acrylonitrile Butadiene Styrene

General Information

Product Description

General purpose V0/5VA-rated ABS

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant		
Features	• Excellent Colorability	• Flame Retardant	
Uses	• Consumer Applications • Household Goods	• Industrial Applications • Industrial Parts	
UL File Number	• E178307		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6000	psi	ASTM D638
Tensile Strength ² (Break)	4300	psi	ASTM D638
Tensile Elongation ² (Yield)	3.0	%	ASTM D638
Tensile Elongation ² (Break)	8.0	%	ASTM D638
Flexural Modulus ²	330000	psi	ASTM D790
Flexural Strength ²	8500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	4.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	165	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.10 in	5VA		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160 to 180	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	50 to 70	%
Rear Temperature	340 to 360	°F
Middle Temperature	390 to 410	°F
Front Temperature	410 to 430	°F
Nozzle Temperature	380 to 430	°F



Processing (Melt) Temp	380 to 450 °F
Mold Temperature	100 to 180 °F
Back Pressure	50.0 to 100 psi
Screw Speed	30 to 60 rpm
Vent Depth	1.5E-3 to 2.0E-3 in

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

