ColorFast® GPA300

Americhem - *Acrylonitrile Butadiene Styrene*

General Information

Product Description			
Super-tough ABS with our highest impact strength, extrusion grade			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Excellent Colorability		
Uses	• Consumer Applications • Household Goods	• Industrial Applications • Industrial Parts	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield)	5800	psi	ASTM D638
Tensile Strength [2] (Break)	4200	psi	ASTM D638
Tensile Elongation [2] (Yield)	3.0	%	ASTM D638
Tensile Elongation [2] (Break)	50	%	ASTM D638
Flexural Modulus [2]	275000	psi	ASTM D790
Flexural Strength [2]	8500	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	7.0	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	107		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	181	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180 to 200	°F
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	30 to 60	%
Rear Temperature	370 to 410	°F
Middle Temperature	400 to 440	°F
Front Temperature	420 to 460	°F
Nozzle Temperature	425 to 500	°F
Processing (Melt) Temp	425 to 500	°F
Mold Temperature	120 to 160	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm
Vent Depth	1.5E-3 to 2.0E-3	in

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