

ColorFast® GPA300X

Americhem - Acrylonitrile Butadiene Styrene

General Information

Product Description

Extrusion grade, high impact, high gloss ABS

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• UV Stabilizer		
Features	• Excellent Colorability	• UV Stabilized	
Uses	• Consumer Applications • Household Goods	• Industrial Applications • Industrial Parts	• Outdoor Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.03		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	7.0	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)	5200	psi	ASTM D638
Tensile Strength ² (Break)	4000	psi	ASTM D638
Tensile Elongation ² (Yield)	3.0	%	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ²	250000	psi	ASTM D790
Flexural Strength ²	7500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	8.0	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		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



Notes

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

² 2.0 in/min

