

ColorFast® FRA205

Acrylonitrile Butadiene Styrene

LTL Color Compounders, Inc.

Message:

Flame-retarded V0, high gloss ABS with superior UV stability

General Information			
UL YellowCard	E178307-226549		
Features	Flame Retardant		
	Good UV Resistance		
	High Gloss		
UL File Number	E178307		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	11	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)	102		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	38.6	MPa	ASTM D638
Tensile Elongation ² (Break)	12	%	ASTM D638
Flexural Modulus ³	2340	MPa	ASTM D790
Flexural Strength ⁴	57.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	72.8	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
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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