

ColorFast® FRPS100

High Impact Polystyrene

LTL Color Compounders, Inc.

Message:

V1-rated high impact styrene

General Information			
Features	High Impact Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 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 (L-Scale)	55		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	19.3	MPa	
Break	20.7	MPa	
Tensile Elongation ² (Break)	40	%	ASTM D638
Flexural Modulus ³	1860	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	82.2	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating	V-1		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	71.1	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	40 to 60	%	
Rear Temperature	171 to 199	°C	
Middle Temperature	193 to 227	°C	
Front Temperature	218 to 254	°C	
Nozzle Temperature	204 to 232	°C	
Processing (Melt) Temp	204 to 238	°C	
Mold Temperature	10.0 to 71.1	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE		
1.	51 mm/min	
2.	51 mm/min	
3.	51 mm/min	

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