

ColorFast® GPA300

ABS

Americhem Engineered Compounds

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	5	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.0065	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	40	MPa	ASTM D 638
Tensile Strength at Break	29	MPa	ASTM D 638
Elongation at Yield	3	%	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	1896	MPa	ASTM D 790
Flexural Strength	58.6	MPa	ASTM D 790
Rockwell Hardness	R107	-	ASTM D 785
Izod Impact notched, 1/8 in	374	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	82.8	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	82.2 - 93.3	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	218 - 260	°C	-
Mold temperature	48.9 - 71.1	°C	-
Zone 1	188 - 210	°C	-
Zone 2	204 - 227	°C	-
Zone 3	216 - 238	°C	-
Nozzle temperature	218 - 260	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics**Processing**

Injection Molding

Features

Low Odor

Delivery form

Pellets

Regional Availability

North America

Special Characteristics

High impact or impact modified