

**ColorFast® GPA300X**

ABS

Americhem Engineered Compounds

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	7	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
<b>ASTM Data</b>			
Tensile Strength at Yield	35.9	MPa	ASTM D 638
Tensile Strength at Break	27.6	MPa	ASTM D 638
Elongation at Yield	3	%	ASTM D 638
Elongation at Break	110	%	ASTM D 638
Flexural Modulus	1724	MPa	ASTM D 790
Flexural Strength	51.7	MPa	ASTM D 790
Rockwell Hardness	R105	-	ASTM D 785
Izod Impact notched, 1/8 in	427	J/m	ASTM D 256

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

Other properties	Value	Unit	Test Standard
Density	1030	kg/m <sup>3</sup>	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, Other Extrusion

**Delivery form**

Pellets

**Special Characteristics**

High impact or impact modified

**Features**

High Gloss, Low Odor

**Regional Availability**

North America