

ColorFast® FRPA100XHF

Americhem - Polycarbonate + ABS

General Information
Product Description

FRPA100XHF is a high flow injection molding grade of polycarbonate and acrylonitrile butadiene (PC+ABS) alloy with high impact and UV stability. It consists of a non halogenated FR system with UL rating of V0@1.5mm.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Flame Retardant		
Features	• Excellent Colorability	• Flame Retardant	• High Flow
Uses	• Automotive Applications	• Engineering Parts	• Industrial Applications
	• Closures	• Household Goods	• Industrial Parts
	• Consumer Applications	• Housings	• Office Automation Equipment
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	8700	psi	ASTM D638
Tensile Strength ² (Break)	8100	psi	ASTM D638
Tensile Elongation ² (Yield)	4.0	%	ASTM D638
Tensile Elongation ² (Break)	85	%	ASTM D638
Flexural Modulus ²	382000	psi	ASTM D790
Flexural Strength ²	13800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	195	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	30 to 60	%
Rear Temperature	410 to 490	°F
Middle Temperature	420 to 500	°F
Front Temperature	440 to 525	°F
Nozzle Temperature	450 to 525	°F
Processing (Melt) Temp	450 to 525	°F



Mold Temperature	140 to 180 °F
Back Pressure	50.0 to 100 psi
Screw Speed	30 to 75 rpm
Vent Depth	1.5E-3 to 3.0E-3 in

Notes

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

² 2.0 in/min

