
Processing Data

Grade FRA204

High gloss, excellent impact ABS, V0/5VA-rated

Injection Molding Parameters	Nominal Values (English)
Drying Temperature	160-180 °F
Drying Time	3-4 Hours
Drying Time, Maximum	8 Hours
Melt Temperature	380-450 °F
Nozzle Temperature	380-430 °F
Front Temperature	410-430 °F
Middle Temperature	390-410 °F
Rear Temperature	340-360 °F
Mold Temperature	160-180 °F
Back Pressure	50-100 psi
Screw Speed	30-60 rpm
Suggested Shot Size	50-70 %
Vent Depth	.0015-.002 in

The values shown are typical values that have been obtained using test bars molded from laboratory samples and are not intended for specification purposes. These values are for natural colors only. Addition of pigments may alter some values. Inasmuch as LTL Color Compounders has no control over the use to which others may put the material, it does not guarantee that the same results as those described herein will be obtained. Each user of the material should make his own test to determine the material's suitability for his own particular use. Statements concerning possible or suggested uses of the materials described herein are not to be construed as constituting a license under any LTL Color Compounders patent covering such use or as recommendations for use of such materials in the infringement of any patent. These are developmental products with estimated physical property profiles. Actual values will need to be determined upon production of material.