

POLYLAC PA-77NB

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	10	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Yield stress	45	MPa	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	21	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	23	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Vicat softening temperature, A	115	°C	ISO 306
Vicat softening temperature, B	108	°C	ISO 306
Coeff. of linear therm. expansion, parallel	84	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Electrical properties			
ASTM Data			
Arc Resistance	90	s	ASTM D 495
Other properties			
Density	1060	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90 - 95	°C	-
Pre-drying - Time	3	h	-
Mold temperature	30 - 70	°C	-
Feed temperature	220 - 240	°C	-
Zone 1	230 - 250	°C	-
Nozzle temperature	230 - 250	°C	-
Injection pressure	5 - 7	MPa	-
Back pressure	0.5 - 1.5	MPa	-
Holding pressure	4 - 6	MPa	-

Characteristics**Processing**

Injection Molding

Features

Low Emission, Low Odor

Delivery form

Pellets

Applications

Automotive

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

Asia Pacific