

POLYLAC PA-727

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	1.6	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	46	MPa	ISO 527
Stress at break	34	MPa	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	71	MPa	ISO 178
Charpy notched impact strength, +23°C	25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	12	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	24	kJ/m ²	ISO 180/1A
Izod notched impact strength	11	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Yield	45.4	MPa	ASTM D 638
Flexural Modulus	2413	MPa	ASTM D 790
Flexural Strength	71	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	283	J/m	ASTM D 256
Izod Impact notched, 1/4 in	251	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	83	°C	ISO 75-1/-2
Vicat softening temperature, A	105	°C	ISO 306
Vicat softening temperature, B	98	°C	ISO 306
Coeff. of linear therm. expansion, parallel	88	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	-
Yellow Card available	yes	-	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	87.8	°C	ASTM D 648
Vicat Temperature	106	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Arc Resistance	30	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	1050	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	30 - 70	°C	-
Feed temperature	180 - 220	°C	-

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Zone 1	190 - 230	°C	-
Nozzle temperature	190 - 230	°C	-

Characteristics**Processing**

Injection Molding

Features

High Gloss

Delivery form

Pellets

Applications

General Purpose

Special Characteristics

Platable, High impact or impact modified

Regional Availability

Asia Pacific