

POLYLAC PA-746

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	29	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	3	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Yield stress	39	MPa	ISO 527
Stress at break	29	MPa	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Flexural strength	60	MPa	ISO 178
Charpy notched impact strength, +23°C	30	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	14	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	28	kJ/m ²	ISO 180/1A
Izod notched impact strength	12	kJ/m ²	ISO 180/1A
Temperature	-10	°C	-
ASTM Data			
Tensile Strength at Yield	40.6	MPa	ASTM D 638
Flexural Modulus	2137	MPa	ASTM D 790
Flexural Strength	63.4	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/8 in	320	J/m	ASTM D 256
Izod Impact notched, 1/4 in	256	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Vicat softening temperature, A	103	°C	ISO 306
Vicat softening temperature, B	94	°C	ISO 306
Coeff. of linear therm. expansion, parallel	92	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	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	85.6	°C	ASTM D 648
Vicat Temperature	105	°C	ASTM D 1525
Electrical properties			
ASTM Data			
Arc Resistance	90	s	ASTM D 495
Other properties			
Density	1030	kg/m ³	ISO 1183
Density	1030	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	2 - 3	h	-
Mold temperature	30 - 60	°C	-
Feed temperature	180 - 220	°C	-
Zone 1	190 - 230	°C	-

POLYLAC PA-746

ABS

CHIMEI Corporation

Nozzle temperature

190 - 230

°C

-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Pellets

Regional Availability

Asia Pacific