

POLYLAC PA-746M

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	50	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	41	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	61	MPa	ISO 178
Charpy notched impact strength, +23°C	20	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	19	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	96 ^[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, A	104	°C	ISO 306
Vicat softening temperature, B	99	°C	ISO 306
Coeff. of linear therm. expansion, parallel	83	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	-

ann.: annealed

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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	-
Nozzle temperature	190 - 230	°C	-

Characteristics**Processing**

Injection Molding

Features

Good Adhesion

Delivery form

Pellets

Regional Availability

Asia Pacific