

POLYLAC PA-747F

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3.5	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	0.3	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Yield stress	46	MPa	ISO 527
Stress at break	33	MPa	ISO 527
Flexural modulus, 23°C	1900	MPa	ISO 178
Flexural strength	66	MPa	ISO 178
Charpy notched impact strength, +23°C	32	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	21	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	30	kJ/m ²	ISO 180/1A
Izod notched impact strength	20	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Yield	47.4	MPa	ASTM D 638
Flexural Modulus	2620	MPa	ASTM D 790
Flexural Strength	71.4	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	331	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	84	°C	ISO 75-1/-2
Vicat softening temperature, A	106	°C	ISO 306
Vicat softening temperature, B	101	°C	ISO 306
Coeff. of linear therm. expansion, parallel	87	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	85.6	°C	ASTM D 648
Vicat Temperature	106	°C	ASTM D 1525
Electrical properties			
ASTM Data			
Arc Resistance	90	s	ASTM D 495
Other properties			
Density	1050	kg/m ³	ISO 1183
Density	1050	kg/m ³	ASTM D 792
Processing Recommendation Extrusion			
Type of extrusion	profile	-	-
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Feed temperature	190 - 210	°C	-

POLYLAC PA-747F

ABS

CHIMEI Corporation

Zone 1	210 - 240	°C	-
Nozzle temperature	220 - 250	°C	-

Characteristics**Processing**

Profile Extrusion

Applications

Refrigeration

Delivery form

Pellets

Regional Availability

Asia Pacific