

**POLYLAC PA-747H**

ABS

CHIMEI Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>3</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.6</b>	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>0.2</b>	g/10min	ASTM D 1238
Temperature	<b>200</b>	°C	-
Load	<b>5</b>	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	<b>46</b>	MPa	ISO 527
Stress at break	<b>35</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>1800</b>	MPa	ISO 178
Flexural strength	<b>63</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>35</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	<b>24</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	<b>33</b>	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	<b>22</b>	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	<b>-30</b>	°C	-
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>47</b>	MPa	ASTM D 638
Flexural Modulus	<b>2344</b>	MPa	ASTM D 790
Flexural Strength	<b>68.3</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 112</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>454</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>320</b>	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>84</b>	°C	ISO 75-1/-2
Vicat softening temperature, A	<b>106</b>	°C	ISO 306
Vicat softening temperature, B	<b>101</b>	°C	ISO 306
Coeff. of linear therm. expansion, parallel	<b>87</b>	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>1.0</b>	mm	-
Yellow Card available	<b>yes</b>	-	-
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
Thickness tested	<b>1.5</b>	mm	-
DTUL @ 264 psi	<b>85.6</b>	°C	ASTM D 648
Vicat Temperature	<b>106</b>	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ASTM Data</b>			
Arc Resistance	<b>90</b>	s	ASTM D 495
<b>Other properties</b>			
Density	<b>1050</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1050</b>	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Extrusion</b>			
Pre-drying - Temperature	<b>80 - 85</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Feed temperature	<b>190 - 210</b>	°C	-
Zone 1	<b>210 - 240</b>	°C	-

Nozzle temperature

**220 - 250**

°C

-

**Characteristics****Processing**

Other Extrusion

**Delivery form**

Pellets

**Chemical Resistance**

General Chemical Resistance

**Applications**

Refrigeration

**Regional Availability**

Asia Pacific