

POLYLAC PA-747S

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	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	0.5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Yield stress	40	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Flexural modulus, 23°C	1700	MPa	ISO 178
Flexural strength	57	MPa	ISO 178
Charpy notched impact strength, +23°C	36	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	25	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	34	kJ/m ²	ISO 180/1A
Izod notched impact strength	23	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Yield	38.1	MPa	ASTM D 638
Flexural Modulus	2068	MPa	ASTM D 790
Flexural Strength	60.7	MPa	ASTM D 790
Rockwell Hardness	R 102	-	ASTM D 785
Izod Impact notched, 1/8 in	400	J/m	ASTM D 256
Izod Impact notched, 1/4 in	347	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	81	°C	ISO 75-1/-2
Vicat softening temperature, A	103	°C	ISO 306
Vicat softening temperature, B	98	°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	-
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	103	°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 Extrusion			
Type of extrusion	sheet	-	-
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Feed temperature	190 - 210	°C	-

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

Characteristics**Processing**

Injection Molding, Sheet Extrusion

Special Characteristics

High impact or impact modified

Delivery form

Pellets

Regional Availability

Asia Pacific