

POLYLAC PA-757 J01

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	17	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	47	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	18	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	19	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	46.5	MPa	ASTM D 638
Flexural Modulus	2594	MPa	ASTM D 790
Flexural Strength	76.4	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	187	J/m	ASTM D 256
Izod Impact notched, 1/4 in	171	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	98 ^[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, A	106	°C	ISO 306
Vicat softening temperature, B	102	°C	ISO 306
Coeff. of linear therm. expansion, parallel	79	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	-
Vicat Temperature	103	°C	ASTM D 1525

ann.: annealed

Other properties	Value	Unit	Test Standard
Density	1050	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 3	h	-
Mold temperature	30 - 70	°C	-
Feed temperature	180 - 220	°C	-
Zone 1	190 - 230	°C	-
Nozzle temperature	190 - 230	°C	-

Characteristics**Processing**

Injection Molding

Applications

Packaging

Delivery form

Pellets, Black

Regional Availability

Asia Pacific

Features

High Gloss