

**POLYLAC PA-764B**

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	26	cm <sup>3</sup> /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	2.8	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	37	MPa	ISO 527
Stress at break	29	MPa	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Flexural strength	57	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	7	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	7	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>ASTM Data</b>			
Tensile Strength at Yield	40.1	MPa	ASTM D 638
Flexural Modulus	2206	MPa	ASTM D 790
Flexural Strength	64.6	MPa	ASTM D 790
Rockwell Hardness	R 102	-	ASTM D 785
Izod Impact notched, 1/8 in	160	J/m	ASTM D 256
Izod Impact notched, 1/4 in	117	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	83	°C	ISO 75-1/-2
Vicat softening temperature, A	102	°C	ISO 306
Vicat softening temperature, B	90	°C	ISO 306
Coeff. of linear therm. expansion, parallel	86.3	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	2.5	mm	-
Yellow Card available	yes	-	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.5	mm	-
Yellow Card available	yes	-	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	2.49	mm	-
DTUL @ 264 psi	80	°C	ASTM D 648
Vicat Temperature	101	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ASTM Data</b>			
Arc Resistance	30	s	ASTM D 495
<b>Other properties</b>			
Density	1160	kg/m <sup>3</sup>	ISO 1183
Density	1160	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Mold temperature	40 - 70	°C	-
Feed temperature	180 - 210	°C	-
Zone 1	190 - 220	°C	-
Nozzle temperature	190 - 220	°C	-
Back pressure	0.5 - 1	MPa	-

## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets

### Additives

Flame retarding agent

### Special Characteristics

Flame retardant, Light stabilized or stable to light, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

### Applications

IT / Business Machine, Electrical and Electronical

### Regional Availability

Asia Pacific