

POLYLAC PA-764G

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	34	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	34	MPa	ISO 527
Stress at break	27	MPa	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Flexural strength	54	MPa	ISO 178
Charpy notched impact strength, +23°C	12	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m ²	ISO 180/1A
Izod notched impact strength	7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Vicat softening temperature, A	101	°C	ISO 306
Vicat softening temperature, B	90	°C	ISO 306
Coeff. of linear therm. expansion, parallel	83	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	2.5	mm	-

Other properties	Value	Unit	Test Standard
Density	1220	kg/m ³	ISO 1183

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, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Applications

IT / Business Machine, Electrical and Electronical

Regional Availability

Asia Pacific