POLYLAC PA-765

ABS — CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**58**	cm³/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**5**	g/10min	ASTM D 1238
Temperature	**200**	°C	-
Load	**5**	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**38**	MPa	ISO 527
Stress at break	**29**	MPa	ISO 527
Flexural modulus, 23°C	**1800**	MPa	ISO 178
Flexural strength	**55**	MPa	ISO 178
Charpy notched impact strength, +23°C	**22**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**10**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**21**	kJ/m²	ISO 180/1A
Izod notched impact strength	**9**	kJ/m²	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 100**	-	ASTM D 785
Izod Impact notched, 1/8 in	**214**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**176**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**74**	°C	ISO 75-1/-2
Vicat softening temperature, A	**91**	°C	ISO 306
Vicat softening temperature, B	**78**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**83.9**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**V-1**	class	IEC 60695-11-10
Thickness tested	**1.0**	mm	-
Yellow Card available	**yes**	-	-
Burning behav. 5V at thickness h	**5VB**	class	IEC 60695-11-20
Thickness tested	**1.5**	mm	-
Yellow Card available	**yes**	-	-
ASTM Data			
UL 94 Flame rating	**V-0**	-	UL 94
Thickness tested	**1.5**	mm	-
DTUL @ 264 psi	**72.8**	°C	ASTM D 648
Vicat Temperature	**90**	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Volume Resistivity	**1E15**	Ohm*cm	ASTM D 257
Arc Resistance	**30**	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	**1190**	kg/m³	ISO 1183
Density	**1190**	kg/m³	ASTM D 792

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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

Applications
IT / Business Machine, Electrical and Electronical

Regional Availability
Asia Pacific