

**POLYLAC PA-765A**

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	<b>48</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.5</b>	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>4.6</b>	g/10min	ASTM D 1238
Temperature	<b>200</b>	°C	-
Load	<b>5</b>	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Yield stress	<b>39</b>	MPa	ISO 527
Stress at break	<b>29</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>1800</b>	MPa	ISO 178
Flexural strength	<b>56</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>23</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	<b>10</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	<b>22</b>	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	<b>10</b>	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	<b>-30</b>	°C	-
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>39.1</b>	MPa	ASTM D 638
Flexural Modulus	<b>2206</b>	MPa	ASTM D 790
Flexural Strength	<b>62.5</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 101</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>235</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>198</b>	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Temp. of deflection under load, 1.80 MPa	<b>76</b>	°C	ISO 75-1/-2
Vicat softening temperature, A	<b>93</b>	°C	ISO 306
Vicat softening temperature, B	<b>79</b>	°C	ISO 306
Coeff. of linear therm. expansion, parallel	<b>84.8</b>	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	<b>V-1</b>	class	IEC 60695-11-10
Thickness tested	<b>1.5</b>	mm	-
Yellow Card available	<b>yes</b>	-	-
Burning behav. at thickness h	<b>V-0</b>	class	IEC 60695-11-10
Thickness tested	<b>2.1</b>	mm	-
Yellow Card available	<b>yes</b>	-	-
Burning behav. 5V at thickness h	<b>5VB</b>	class	IEC 60695-11-20
Thickness tested	<b>2.1</b>	mm	-
Yellow Card available	<b>yes</b>	-	-
<b>ASTM Data</b>			
UL 94 Flame rating	<b>V-1</b>	-	UL 94
Thickness tested	<b>1.5</b>	mm	-
DTUL @ 264 psi	<b>76.1</b>	°C	ASTM D 648
Vicat Temperature	<b>92.2</b>	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ASTM Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Arc Resistance	<b>30</b>	s	ASTM D 495
<b>Other properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
Density	<b>1170</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1170</b>	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

#### Applications

IT / Business Machine, Electrical and Electronical

#### Regional Availability

Asia Pacific