

POLYLAC PA-765B

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	44	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	4.2	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data	Value	Unit	Test Standard
Yield stress	39	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Flexural strength	57	MPa	ISO 178
Charpy notched impact strength, +23°C	25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	11	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	24	kJ/m ²	ISO 180/1A
Izod notched impact strength	11	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Yield	39.1	MPa	ASTM D 638
Flexural Modulus	2344	MPa	ASTM D 790
Flexural Strength	63.4	MPa	ASTM D 790
Rockwell Hardness	R 102	-	ASTM D 785
Izod Impact notched, 1/8 in	246	J/m	ASTM D 256
Izod Impact notched, 1/4 in	214	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	77	°C	ISO 75-1/-2
Vicat softening temperature, A	94	°C	ISO 306
Vicat softening temperature, B	80	°C	ISO 306
Coeff. of linear therm. expansion, parallel	85.5	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
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	-	-
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	76.1	°C	ASTM D 648
Vicat Temperature	92.2	°C	ASTM D 1525
Electrical properties			
ASTM Data	Value	Unit	Test Standard
Arc Resistance	30	s	ASTM D 495
Other properties			
Value	Unit	Test Standard	
Density	1160	kg/m ³	ISO 1183
Density	1160	kg/m ³	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

Special Characteristics

Flame retardant

Delivery form

Pellets

Applications

IT / Business Machine, Electrical and Electronical

Additives

Flame retarding agent

Regional Availability

Asia Pacific