

POLYLAC PA-777B

ABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	8.5	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	7.5	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mechanical properties			
ISO Data			
Yield stress	44	MPa	ISO 527
Stress at break	34	MPa	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	67	MPa	ISO 178
Charpy notched impact strength, +23°C	22	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	21	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	43	MPa	ASTM D 638
Flexural Modulus	2137	MPa	ASTM D 790
Flexural Strength	63.4	MPa	ASTM D 790
Rockwell Hardness	R 112	-	ASTM D 785
Izod Impact notched, 1/8 in	230	J/m	ASTM D 256
Izod Impact notched, 1/4 in	198	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Vicat softening temperature, A	113	°C	ISO 306
Vicat softening temperature, B	106	°C	ISO 306
Coeff. of linear therm. expansion, parallel	84	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	97.2	°C	ASTM D 648
Vicat Temperature	115	°C	ASTM D 1525
Electrical properties			
ASTM Data			
Arc Resistance	30	s	ASTM D 495
Other properties			
Density	1030	kg/m ³	ISO 1183
Density	1030	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90 - 95	°C	-
Pre-drying - Time	3	h	-
Mold temperature	30 - 70	°C	-
Feed temperature	220 - 240	°C	-

POLYLAC PA-777B

ABS

CHIMEI Corporation

Zone 1	230 - 250	°C	-
Nozzle temperature	230 - 250	°C	-
Injection pressure	5 - 7	MPa	-
Back pressure	0.5 - 1.5	MPa	-
Holding pressure	4 - 6	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets

Regional Availability

Asia Pacific

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat