

**POLYLAC PA-777D**

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	5.5	cm <sup>3</sup> /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	5.5	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	43	MPa	ISO 527
Stress at break	33	MPa	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	73	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	7	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	7	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>ASTM Data</b>			
Tensile Strength at Yield	44	MPa	ASTM D 638
Flexural Modulus	2206	MPa	ASTM D 790
Flexural Strength	66.5	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	171	J/m	ASTM D 256
Izod Impact notched, 1/4 in	139	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	97	°C	ISO 75-1/-2
Vicat softening temperature, A	124	°C	ISO 306
Vicat softening temperature, B	117	°C	ISO 306
Coeff. of linear therm. expansion, parallel	83	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	-	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	105	°C	ASTM D 648
Vicat Temperature	125	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ASTM Data</b>			
Arc Resistance	30	s	ASTM D 495
<b>Other properties</b>			
Density	1060	kg/m <sup>3</sup>	ISO 1183
Density	1060	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	90 - 105	°C	-
Pre-drying - Time	3	h	-
Mold temperature	30 - 70	°C	-
Feed temperature	220 - 240	°C	-

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

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive

**Delivery form**

Pellets

**Regional Availability**

Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat