POLYLAC PA-797

ABS — CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**9.2**	cm³/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**1**	g/10min	ASTM D 1238
Temperature	**200**	°C	-
Load	**0.5**	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**43**	MPa	ISO 527
Stress at break	**33**	MPa	ISO 527
Flexural modulus, 23°C	**1100**	MPa	ISO 178
Flexural strength	**51**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**35.5**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**35**	kJ/m²	ISO 180/1A
ASTM Data			
Tensile Strength at Yield	**41.2**	MPa	ASTM D 638
Flexural Modulus	**1989**	MPa	ASTM D 790
Flexural Strength	**59.8**	MPa	ASTM D 790
Rockwell Hardness	**R 108**	-	ASTM D 785
Izod Impact notched, 1/8 in	**400**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**267**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**80**	°C	ISO 75-1/-2
Vicat softening temperature, A	**105**	°C	ISO 306
Vicat softening temperature, B	**95**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**88**	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	**1.59**	mm	-
Vicat Temperature	**106**	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Arc Resistance	**90**	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	**1050**	kg/m³	ISO 1183
Density	**1050**	kg/m³	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	**30 - 70**	°C	-
Feed temperature	**180 - 220**	°C	-
Zone 1	**190 - 230**	°C	-
Nozzle temperature	**190 - 230**	°C	-

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Characteristics

Processing
Injection Molding

Delivery form
Pellets

Special Characteristics
High impact or impact modified

Chemical Resistance
General Chemical Resistance

Regional Availability
Asia Pacific