

POLYLAC PA-758

MABS

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3	cm ³ /10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	42	MPa	ISO 527
Stress at break	33	MPa	ISO 527
Flexural modulus, 23°C	1900	MPa	ISO 178
Flexural strength	57	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	14	kJ/m ²	ISO 180/1A
Izod notched impact strength	7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Yield	40.3	MPa	ASTM D 638
Flexural Modulus	1862	MPa	ASTM D 790
Flexural Strength	53.6	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/8 in	149	J/m	ASTM D 256
Izod Impact notched, 1/4 in	160	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	77	°C	ISO 75-1/-2
Vicat softening temperature, A	104	°C	ISO 306
Vicat softening temperature, B	96	°C	ISO 306
Coeff. of linear therm. expansion, parallel	90	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	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.59	mm	-
DTUL @ 264 psi	87.8	°C	ASTM D 648
Vicat Temperature	105	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1080	kg/m ³	ISO 1183
Density	1080	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	3 - 5	h	-
Melt temperature	230 - 240	°C	-
Mold temperature	50 - 70	°C	-
Feed temperature	200 - 220	°C	-
Zone 1	220 - 250	°C	-
Nozzle temperature	220 - 250	°C	-
Injection pressure	5 - 8	MPa	-
Back pressure	0.5 - 1	MPa	-

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Holding pressure

2 - 5

MPa

-

Characteristics**Processing**

Injection Molding

Special Characteristics

Transparent

Delivery form

Pellets

Regional Availability

Asia Pacific