

**POLYLAC PA-758R**

MABS

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	2.2	cm <sup>3</sup> /10min	ISO 1133
Temperature	220	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	2.2	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Yield stress	45	MPa	ISO 527
Stress at break	33	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	62	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	8	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>ASTM Data</b>			
Tensile Strength at Yield	39.4	MPa	ASTM D 638
Flexural Modulus	2068	MPa	ASTM D 790
Flexural Strength	59.6	MPa	ASTM D 790
Rockwell Hardness	R 110	-	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

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
Vicat softening temperature, A	102	°C	ISO 306
Vicat softening temperature, B	94	°C	ISO 306
Coeff. of linear therm. expansion, parallel	87	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	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.59	mm	-
DTUL @ 264 psi	86.1	°C	ASTM D 648
Vicat Temperature	102	°C	ASTM D 1525

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

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**Chemical Resistance**

General Chemical Resistance

**Delivery form**

Pellets

**Regional Availability**

Asia Pacific

**Special Characteristics**

Transparent