

POLYLAC® PA-765B

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC®PA-765B is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.

- Features include:
- flame retardant/rated flame
 - ROHS certification
 - Flame Retardant
 - high liquidity
 - Impact resistance

General Information			
UL YellowCard	E56070-565070	E56070-565073	
Additive	Flame retardancy		
Features	High liquidity		
	Medium impact resistance		
	Flame retardancy		
RoHS Compliance	RoHS compliance		
UL File Number	E56070		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.16	g/cm ³	ASTM D792
23°C	1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
200°C/5.0 kg	4.2	g/10 min	ASTM D1238
220°C/10.0 kg	42	g/10 min	ASTM D1238
220°C/10.0 kg	45	g/10 min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 12.7 mm)	102		ASTM D785
Ball Indentation Hardness (H 358/30)	82.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 3.18mm ¹	39.1	MPa	ASTM D638
Yield	41.0	MPa	ISO 527-2/50
Fracture	30.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture, 3.18mm ²	25	%	ASTM D638

Fracture	10	%	ISO 527-2/50
Flexural Modulus			
6.35 mm ³	196	MPa	ASTM D790
-- ⁴	1800	MPa	ISO 178
Flexural Strength			
6.35 mm ⁵	63.4	MPa	ASTM D790
-- ⁶	57.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	20	kJ/m ²	ISO 179
Notched Izod Impact			
23°C, 3.18 mm	250	J/m	ASTM D256
23°C, 6.35 mm	220	J/m	ASTM D256
--	20	kJ/m ²	ISO 180/1A
Impact Flexural Test - Notched	13.0	kJ/m ²	ISO 179/2C
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 6.35mm	76.1	°C	ASTM D648
1.8 MPa, not annealed	77.0	°C	ISO 75-2/A
1.8 MPa, annealed	85.0	°C	ASTM D648
1.8 MPa, annealed	91.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	92.0	°C	ASTM D1525, ISO 306/A120 6 ⁷
--	95.0	°C	ISO 306/A50
--	80.0	°C	ISO 306/B50
--	82.0	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.50 mm, ALL	V-2	UL 94	
	V-0		
2.50 mm, ALL	5VB	UL 94	
3.00 mm, ALL	5VA	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	180 - 210	°C	
Middle Temperature	190 - 220	°C	
Front Temperature	190 - 220	°C	
Nozzle Temperature	190 - 220	°C	
Mold Temperature	40.0 - 70.0	°C	

Back Pressure	0.490 - 0.981	MPa
Cushion	3.18	mm

Injection instructions

Injection Pressure: 50 to 80%Holding Pressure: 20 to 50%

NOTE

1.	6.0 mm/min
2.	6.0 mm/min
3.	2.8 mm/min
4.	2.0 mm/min
5.	2.8 mm/min
6.	2.0 mm/min
7.	速率 A (50°C/h)

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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