

POLYLAC® PA-765

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-765 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

Characteristics include:

Flame Rated

RoHS Compliant

General Information			
UL YellowCard	E56070-565073	E56070-101317482	
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	5.0	g/10 min	
220°C/10.0 kg	56	g/10 min	
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	49.0	cm³/10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Ball Indentation Hardness (H 358/30)	79.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	39.0	MPa	ISO 527-2/50
Break	34.0	MPa	ISO 527-2/50
3.00 mm ¹	38.2	MPa	ASTM D638
Tensile Elongation			
Break, 3.00 mm ²	15	%	ASTM D638
Break	10	%	ISO 527-2/50
Flexural Modulus			
6.00 mm ³	2060	MPa	ASTM D790
-- ⁴	1800	MPa	ISO 178
Flexural Strength			
6.00 mm ⁵	60.8	MPa	ASTM D790
-- ⁶	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	20	kJ/m²	ISO 179
Notched Izod Impact			
23°C, 3.00 mm	220	J/m	ASTM D256

23°C, 6.00 mm	180	J/m	ASTM D256
--	17	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	73.0	°C	ASTM D648
1.8 MPa, Unannealed	74.0	°C	ISO 75-2/A
1.8 MPa, Annealed	83.0	°C	ASTM D648
1.8 MPa, Annealed	90.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	90.0	°C	ASTM D1525, ISO 306/A50 6 ⁷
--	78.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.00 mm	V-1		
1.50 mm	V-0		
1.60 mm	V-0		
2.50 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	180 to 210	°C	
Middle Temperature	190 to 220	°C	
Front Temperature	190 to 220	°C	
Mold Temperature	40.0 to 70.0	°C	
Injection Pressure	4.90 to 7.85	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	1.96 to 4.90	MPa	
Back Pressure	0.490 to 0.981	MPa	
Cushion	3.18	mm	
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.	Rate A (50°C/h)		

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