

POLYLAC® PA-747H

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-747H is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by extrusion and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Typical application: Automotive.

Characteristics include:

Flame Rated

RoHS Compliant

General Information			
UL YellowCard	E56070-550778		
RoHS Compliance	RoHS Compliant		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	0.23	g/10 min	
220°C/10.0 kg	2.8	g/10 min	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	50	%	ASTM D638
Flexural Modulus ³ (6.00 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (6.00 mm)	68.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.00 mm	440	J/m	
23°C, 6.00 mm	310	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed	85.0	°C	
1.8 MPa, Annealed	95.0	°C	
Vicat Softening Temperature	106	°C	ASTM D1525 ⁵
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	
Cylinder Zone 1 Temp.	190 to 210	°C	

Cylinder Zone 3 Temp.	210 to 240	°C
Cylinder Zone 5 Temp.	220 to 250	°C
Die Temperature	200 to 250	°C

NOTE		
1.	6.0 mm/min	
2.	6.0 mm/min	
3.	2.8 mm/min	
4.	2.8 mm/min	
5.	Rate A (50°C/h)	

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