POLYLAC® PA-747

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-747 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. Typical application: Automotive.
Characteristics include:
Flame Rated
RoHS Compliant

General Information			
UL YellowCard	E56070-245718		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity			
--	1.03	g/cm³	ASTM D792
23°C	1.03	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	1.1	g/10 min	
220°C/10.0 kg	13	g/10 min	
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	13.0	cm³/10min	ISO 1133
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	108		ASTM D785
Ball Indentation Hardness (H 358/30)	88.0	MPa	ISO 2039-1
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress			
Yield	39.0	MPa	ISO 527-2/50
Break	31.0	MPa	ISO 527-2/50
3.00 mm [1]	37.8	MPa	ASTM D638
Tensile Elongation			
Break, 3.00 mm [2]	30	%	ASTM D638
Break	45	%	ISO 527-2/50
Flexural Modulus			
6.00 mm [3]	2160	MPa	ASTM D790
-- [4]	1800	MPa	ISO 178
Flexural Strength			
6.00 mm [5]	60.8	MPa	ASTM D790
-- [6]	58.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	37	kJ/m²	ISO 179

Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact			
23°C, 3.00 mm	400	J/m	ASTM D256
23°C, 6.00 mm	310	J/m	ASTM D256
--	34	kJ/m^2	ISO 180/1A
Unnotched Izod Impact Strength	No Break		ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
1.8 MPa, Unannealed	85.0	°C	ASTM D648
1.8 MPa, Unannealed	86.0	°C	ISO 75-2/A
1.8 MPa, Annealed	95.0	°C	ASTM D648
1.8 MPa, Annealed	96.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	103	°C	ASTM D1525 [7]
--	101	°C	ISO 306/A50
--	92.0	°C	ISO 306/B50
Flammability	**Nominal Value**		**Test Method**
Flame Rating (1.60 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	180 to 220	°C	
Middle Temperature	190 to 230	°C	
Front Temperature	190 to 230	°C	
Mold Temperature	30.0 to 70.0	°C	
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)		

Recommended distributors for this material

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