

POLYLAC® PA-764

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-764 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	E56070-565072		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	3.2	g/10 min	
220°C/10.0 kg	32	g/10 min	
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	30.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	98		ASTM D785
Ball Indentation Hardness (H 358/30)	75.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	39.0	MPa	ISO 527-2/50
Break	29.0	MPa	ISO 527-2/50
3.00 mm ¹	36.3	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	1960	MPa	ASTM D790
-- ⁴	1700	MPa	ISO 178
Flexural Strength			
6.00 mm ⁵	57.9	MPa	ASTM D790
-- ⁶	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	14	kJ/m ²	ISO 179
Notched Izod Impact			
23°C, 3.00 mm	140	J/m	ASTM D256

23°C, 6.00 mm	120	J/m	ASTM D256
--	13	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	78.0	°C	ASTM D648
1.8 MPa, Unannealed	74.0	°C	ISO 75-2/A
1.8 MPa, Annealed	92.0	°C	ASTM D648
1.8 MPa, Annealed	96.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	97.0	°C	ASTM D1525 ⁷
--	99.0	°C	ISO 306/A50
--	84.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
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)		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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

