

POLYLAC® PA-756H

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-756H 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

High Flow

General Information			
UL YellowCard	E56070-245725	E56070-245724	
Features	High Flow		
RoHS Compliance	RoHS Compliant		
UL File Number	E56070		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.05	g/cm ³	ASTM D792
23°C	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
200°C/5.0 kg	8.0	g/10 min	ASTM D1238
220°C/10.0 kg	75	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 12.7 mm)	115		ASTM D785
Ball Indentation Hardness (H 358/30)	107	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 3.18 mm ¹	39.2	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/50
Break	34.0	MPa	ISO 527-2/50
Tensile Elongation			
Break, 3.18 mm ²	10	%	ASTM D638
Break	35	%	ISO 527-2/50
Flexural Modulus			
6.35 mm ³	2260	MPa	ASTM D790
-- ⁴	2200	MPa	ISO 178
Flexural Strength			
6.35 mm ⁵	62.8	MPa	ASTM D790
-- ⁶	65.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	8.0	kJ/m ²	ISO 179
Notched Izod Impact			
23°C, 3.18 mm	100	J/m	ASTM D256
23°C, 6.35 mm	90	J/m	ASTM D256
--	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	50	kJ/m ²	ISO 180/1U
Impact Flexural Test			
Notched	8.00	kJ/m ²	ISO 179/2C
Unnotched	110	kJ/m ²	ISO 179/2D
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.35 mm	85.0	°C	ASTM D648
1.8 MPa, Unannealed	89.0	°C	ISO 75-2/A
1.8 MPa, Annealed	95.0	°C	ASTM D648
1.8 MPa, Annealed	97.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	105	°C	ASTM D1525 ⁷
--	102	°C	ISO 306/A50
--	104	°C	ISO 306/A120
--	95.0	°C	ISO 306/B50
--	97.0	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.50 mm, ALL	HB		
1.59 mm	HB		
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	
Nozzle 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)		

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