

POLYLAC® PA-757GJ08

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC®PA-757GJ08 is an acrylonitrile butadiene styrene (ABS) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.

Features include:

- flame retardant/rated flame
- ROHS certification
- high gloss

General Information			
UL YellowCard	E56070-565071		
Features	Highlight		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Resin ID (ISO 1043)	>ABS		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.04	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	29.0	cm³/10min	ISO 1133
Molding Shrinkage	0.40 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			ISO 527-2/50
Yield	42.0	MPa	ISO 527-2/50
Fracture	32.0	MPa	ISO 527-2/50
Tensile Strain (Break)	35	%	ISO 527-2/50
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress ²	63.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	20	kJ/m²	ISO 179
Notched Izod Impact (23°C)	19	kJ/m²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Annealed)	97.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	105	°C	ISO 306/A50
--	99.0	°C	ISO 306/B50
CLTE - Flow	7.9E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.5 mm)	HB		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	80 - 85	°C
Drying Time	3.0 - 4.0	hr
Rear Temperature	180 - 220	°C
Middle Temperature	190 - 230	°C
Front Temperature	190 - 230	°C
Mold Temperature	80 - 120	°C
Back Pressure	0.490 - 0.981	MPa

Injection instructions

Injection Pressure: 50 to 60% Holding Pressure: 40 to 50%

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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Recommended distributors for this material

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

