

# POLYLAC® PA-709P

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-709P 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.

Characteristics include:

- Flame Rated
- RoHS Compliant

| General Information                         |                |                        |              |
|---------------------------------------------|----------------|------------------------|--------------|
| UL YellowCard                               | E56070-245707  |                        |              |
| RoHS Compliance                             | RoHS Compliant |                        |              |
| Processing Method                           | Extrusion      |                        |              |
| Physical                                    | Nominal Value  | Unit                   | Test Method  |
| Density (23°C)                              | 1.03           | g/cm <sup>3</sup>      | ISO 1183     |
| Melt Volume-Flow Rate (MVR) (220°C/10.0 kg) | 8.50           | cm <sup>3</sup> /10min | ISO 1133     |
| Hardness                                    | Nominal Value  | Unit                   | Test Method  |
| Ball Indentation Hardness (H 358/30)        | 86.0           | MPa                    | ISO 2039-1   |
| Mechanical                                  | Nominal Value  | Unit                   | Test Method  |
| Tensile Stress                              |                |                        | ISO 527-2/50 |
| Yield                                       | 45.0           | MPa                    |              |
| Break                                       | 36.0           | MPa                    |              |
| Tensile Strain (Break)                      | 60             | %                      | ISO 527-2/50 |
| Flexural Modulus <sup>1</sup>               | 1900           | MPa                    | ISO 178      |
| Flexural Stress <sup>2</sup>                | 58.0           | MPa                    | ISO 178      |
| Impact                                      | Nominal Value  | Unit                   | Test Method  |
| Charpy Notched Impact Strength              | 27             | kJ/m <sup>2</sup>      | ISO 179      |
| Charpy Unnotched Impact Strength            | No Break       |                        | ISO 179      |
| Notched Izod Impact Strength                | 27             | kJ/m <sup>2</sup>      | ISO 180/1A   |
| Unnotched Izod Impact Strength              | No Break       |                        | ISO 180/1U   |
| Thermal                                     | Nominal Value  | Unit                   | Test Method  |
| Heat Deflection Temperature                 |                |                        | ISO 75-2/A   |
| 1.8 MPa, Unannealed                         | 80.0           | °C                     |              |
| 1.8 MPa, Annealed                           | 98.0           | °C                     |              |
| Vicat Softening Temperature                 |                |                        |              |
| --                                          | 103            | °C                     | ISO 306/A50  |
| --                                          | 95.0           | °C                     | ISO 306/B50  |
| 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. 2.0 mm/min
2. 2.0 mm/min

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