

POLYLAC® PA-758R

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-758R 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	E56070-563742	E56070-245728	
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.08	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	27.3	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			ISO 527-2/50
Yield	44.8	MPa	
Break	33.0	MPa	
Tensile Strain (Break)	60	%	ISO 527-2/50
Flexural Modulus ¹	2000	MPa	ISO 178
Flexural Stress ²	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
--	14	kJ/m²	ISO 179
--	11	kJ/m²	ISO 179/2C
Charpy Unnotched Impact Strength			
--	51	kJ/m²	ISO 179
--	57	kJ/m²	ISO 179/2U
Notched Izod Impact Strength	14	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength	55	kJ/m²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed	77.6	°C	
1.8 MPa, Annealed	96.0	°C	
Vicat Softening Temperature			
--	102	°C	ISO 306/A50
--	105	°C	ISO 306/A120
--	93.8	°C	ISO 306/B50

--	97.2	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating (1.59 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	220 to 250	°C	
Front Temperature	220 to 250	°C	
Processing (Melt) Temp	230 to 240	°C	
Mold Temperature	50.0 to 70.0	°C	
Injection Pressure	4.90 to 7.85	MPa	
Holding Pressure	1.96 to 4.90	MPa	
Back Pressure	0.490 to 0.981	MPa	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		

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