POLYLAC® PA-757GJ08

CHI MEI CORPORATION - Acrylonitrile Butadiene Styrene

Sunday, November 3, 2019

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Gloss		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Resin ID (ISO 1043)	• >ABS<		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.04	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	29	cm³/10min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield)	6090	psi	ISO 527-2/50
Tensile Stress (Break)	4640	psi	ISO 527-2/50
Tensile Strain (Break)	35	%	ISO 527-2/50
Flexural Modulus [2]	305000	psi	ISO 178
Flexural Stress [2]	9140	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	9.5	ft·lb/in²	ISO 179
Notched Izod Impact Strength (73°F)	9.0	ft·lb/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Annealed)	207	°F	ISO 75-2/A
Vicat Softening Temperature			
--	221	°F	ISO 306/A50
--	210	°F	ISO 306/B50
CLTE - Flow	4.4E-5	in/in/°F	ISO 11359-2
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 185	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	356 to 428	°F
Middle Temperature	374 to 446	°F
Front Temperature	374 to 446	°F
Mold Temperature	176 to 248	°F
Back Pressure	71.1 to 142	psi

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Injection Notes

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

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 0.079 in/min