



POLYLAC® PA-765

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 Flow		
RoHS Compliance	• RoHS Compliant		
Resin ID (ISO 1043)	• >ABS-FR(17)<		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.19		ASTM D792
Density (73°F)	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	50	cm ³ /10min	ISO 1133
Molding Shrinkage	0.30 to 0.60	%	ISO 294-4

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³ (Yield)	5530	psi	ASTM D638
Tensile Stress (Yield)	5370	psi	ISO 527-2/50
Tensile Stress (Break)	4060	psi	ISO 527-2/50
Tensile Elongation ³ (Break)	15	%	ASTM D638
Tensile Strain (Break)	10	%	ISO 527-2/50
Flexural Modulus ⁴	300000	psi	ASTM D790
Flexural Modulus ⁵	261000	psi	ISO 178
Flexural Strength ⁴	8800	psi	ASTM D790
Flexural Stress ⁵	7980	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-22°F	4.8	ft-lb/in ²	
73°F	11	ft-lb/in ²	
Notched Izod Impact			ASTM D256
73°F, 0.126 in	4.0	ft-lb/in	
73°F, 0.252 in	3.3	ft-lb/in	
Notched Izod Impact Strength			ISO 180/1A
-22°F	4.3	ft-lb/in ²	
73°F	10	ft-lb/in ²	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	163	°F	
Heat Deflection Temperature (264 psi, Unannealed)	165	°F	ISO 75-2/A
Deflection Temperature Under Load (264 psi, Annealed)	181	°F	ASTM D648

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Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Annealed)	181	°F	ISO 75-2/A
Vicat Softening Temperature	194	°F	ASTM D1525 ⁶
Vicat Softening Temperature			
--	196	°F	ISO 306/A50
--	172	°F	ISO 306/B50
CLTE - Flow	4.7E-5	in/in/°F	ISO 11359-2
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.04 in		V-1	
0.06 in	•	V-0	
	•	5VB	
0.10 in		5VA	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 185	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	356 to 410	°F
Middle Temperature	374 to 428	°F
Front Temperature	374 to 428	°F
Mold Temperature	104 to 158	°F
Injection Pressure	711 to 1140	psi
Injection Rate	Slow-Moderate	
Holding Pressure	284 to 711	psi
Back Pressure	71.1 to 142	psi
Cushion	0.125	in

Notes

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

² 23°C

³ 0.24 in/min

⁴ 0.11 in/min

⁵ 0.079 in/min

⁶ Rate A (50°C/h), Loading 1 (10 N)