

Chi Mei Polylac® PA-765 ABS - Flame Retardant

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Unreinforced, Flame Retardant

Material Notes:

F.R. High Flow

Order this product through the following link:

http://www.lookpolymers.com/polymer_Chi-Mei-Polylac-PA-765-ABS-Flame-Retardant.php

Physical Properties	Metric	English	Comments
Density	1.19 g/cc	0.0430 lb/in ³	ISO 1183
Linear Mold Shrinkage	0.0030 - 0.0070 cm/cm	0.0030 - 0.0070 in/in	ASTM D955
Melt Flow	5.2 g/10 min	5.2 g/10 min	ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	
	60 g/10 min	60 g/10 min	ISO-1133
	@Load 10.0 kg, Temperature 220 °C	@Load 22.0 lb, Temperature 428 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	100	100	ASTM D785
Ball Indentation Hardness	79.0 MPa	11500 psi	H358/30; ISO 2039-1
Tensile Strength at Break	34.0 MPa	4930 psi	50 mm/min; ISO 527
Tensile Strength, Yield	39.0 MPa	5660 psi	50 mm/min; ISO 527
Elongation at Break	10 %	10 %	50 mm/min; ISO 527
Flexural Strength	55.0 MPa	7980 psi	2 mm/min; ISO 178
Flexural Modulus	1.80 GPa	261 ksi	2 mm/min; ISO 178
Izod Impact, Notched	1.83 J/cm	3.43 ft-lb/in	ASTM D256
	@Thickness 6.35 mm	@Thickness 0.250 in	
	2.22 J/cm	4.16 ft-lb/in	ASTM D256
	@Thickness 3.17 mm	@Thickness 0.125 in	
Izod Impact, Notched (ISO)	17.0 kJ/m ²	8.09 ft-lb/in ²	ISO 180/1A
Izod Impact, Unnotched (ISO)	NB	NB	ISO 180/1C
Charpy Impact Unnotched	NB	NB	ISO 179

Charpy Impact, Notched Mechanical Properties	2.00 J/cm ² Metric	9.52 ft-lb/in ² English	ISO 179 Comments
Impact	12.0	12.0	Impact Flexural Test Notched (KJ/m ²)
	NB	NB	Impact Flexural Test Unnotched (KJ/m ²)

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	74.0 °C	165 °F	unannealed; ISO 75
	90.0 °C	194 °F	annealed; ISO 75
Vicat Softening Point	78.0 °C	172 °F	50°C/hr; ISO 306
	@Load 5.00 kg	@Load 11.0 lb	
	80.0 °C	176 °F	120°C/hr; ISO 306
	@Load 5.00 kg	@Load 11.0 lb	
90.0 °C	194 °F	120°C/hr; ISO 306	
@Load 1.00 kg	@Load 2.20 lb		
90.0 °C	194 °F	50°C/hr; ISO 306	
@Load 1.00 kg	@Load 2.20 lb		
Flammability, UL94	V-0	V-0	UL 94
	@Thickness 1.59 mm	@Thickness 0.0625 in	
	5VA	5VA	UL 94
	@Thickness 2.54 mm	@Thickness 0.100 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	177 °C	350 °F	
Middle Barrel Temperature	204 °C	400 °F	
Front Barrel Temperature	216 °C	420 °F	
Melt Temperature	232 - 249 °C	450 - 480 °F	Nozzle temp not greater than stock
Mold Temperature	54.4 - 71.1 °C	130 - 160 °F	
Drying Temperature	87.8 - 93.3 °C	190 - 200 °F	
Dry Time	2 - 24.0 hour	2 - 24.0 hour	
Injection Pressure	55.2 - 82.7 MPa	8000 - 12000 psi	
Back Pressure	0.689 MPa	100 psi	

Processing Properties

Metric rpm

English rpm

Comments

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