

POLYLAC® PA-764

Acrylonitrile Butadiene Styrene
CHI MEI CORPORATION

PROSPECTOR®

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Technical Data

Product Description

POLYLAC® PA-764 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

Characteristics include:

- Flame Rated
- RoHS Compliant
- Weather Resistant

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Features	• Weather Resistant
RoHS Compliance	• RoHS Compliant
Resin ID (ISO 1043)	• >ABS-FR(17)<

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity			
--2	1.19	1.19 g/cm ³	ASTM D792
73°F (23°C)	1.19 g/cm ³	1.19 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.2 g/10 min	3.2 g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	1.83 in ³ /10min	30.0 cm ³ /10min	ISO 1133
Molding Shrinkage	0.30 to 0.60 %	0.30 to 0.60 %	ISO 294-4

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength			
Yield ³	5250 psi	36.2 MPa	ASTM D638
Yield	5370 psi	37.0 MPa	ISO 527-2/50
Break	4060 psi	28.0 MPa	ISO 527-2/50
Tensile Elongation			
Break ³	15 %	15 %	ASTM D638
Break	10 %	10 %	ISO 527-2/50
Flexural Modulus			
--4	280000 psi	1930 MPa	ASTM D790
--5	247000 psi	1700 MPa	ISO 178
Flexural Strength			
--4	8360 psi	57.6 MPa	ASTM D790
--5	7980 psi	55.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179
-22°F (-30°C)	3.3 ft·lb/in ²	7.0 kJ/m ²	
73°F (23°C)	6.2 ft·lb/in ²	13 kJ/m ²	
Notched Izod Impact			
73°F (23°C), 0.126 in (3.20 mm)	2.6 ft·lb/in	140 J/m	ASTM D256
73°F (23°C), 0.252 in (6.40 mm)	2.2 ft·lb/in	120 J/m	ASTM D256
-22°F (-30°C)	3.3 ft·lb/in ²	7.0 kJ/m ²	ISO 180/1A
73°F (23°C)	6.2 ft·lb/in ²	13 kJ/m ²	ISO 180/1A

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	98	98	ASTM D785



Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
264 psi (1.8 MPa), Unannealed	172 °F	78.0 °C	ASTM D648
264 psi (1.8 MPa), Unannealed	180 °F	82.0 °C	ISO 75-2/A
264 psi (1.8 MPa), Annealed	198 °F	92.0 °C	ASTM D648 ISO 75-2/A
Vicat Softening Temperature			
--	207 °F	97.0 °C	ASTM D1525 ⁶
--	214 °F	101 °C	ISO 306/A50
--	194 °F	90.0 °C	ISO 306/B50
CLTE - Flow	4.7E-5 in/in/°F	8.5E-5 cm/cm/°C	ISO 11359-2
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating			UL 94
0.06 in (1.5 mm)	• V-0	• V-0	
	• 5VB	• 5VB	
0.10 in (2.5 mm)	5VA	5VA	

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	356 to 410 °F	180 to 210 °C
Middle Temperature	374 to 428 °F	190 to 220 °C
Front Temperature	374 to 428 °F	190 to 220 °C
Mold Temperature	104 to 158 °F	40 to 70 °C
Injection Pressure	711 to 1140 psi	4.90 to 7.85 MPa
Injection Rate	Slow-Moderate	Slow-Moderate
Holding Pressure	284 to 711 psi	1.96 to 4.90 MPa
Back Pressure	71.1 to 142 psi	0.490 to 0.981 MPa
Cushion	0.125 in	3.18 mm

Notes

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

² 23°C

³ 0.24 in/min (6.0 mm/min)

⁴ 0.11 in/min (2.8 mm/min)

⁵ 0.079 in/min (2.0 mm/min)

⁶ Rate A (50°C/h), Loading 1 (10 N)



Where to Buy

Supplier

CHI MEI CORPORATION
Tainan County, Taiwan
Telephone: +886-6-266-3000
Web: <http://www.chimeicorp.com/>

Distributor

A. Westensee und Partner Rohstoff GmbH
Telephone: +49-4171-8812-0
Web: <http://www.awp-rohstoffe.de/>
Availability: Germany

AMP FRANCE
Telephone: +33-3-8920-1390
Web: <http://www.amp.fr/>
Availability: France

AMP TUNISIA
Telephone: +216-52-27-21-73
Web: <http://www.amp.fr/>
Availability: Tunisia

Biesterfeld Plastic GmbH
Biesterfeld Plastic GmbH is a Pan European distribution company. Contact Biesterfeld Plastic GmbH for availability of individual products by country.
Telephone: +49-40-32008-0
Web: <http://www.biesterfeld-plastic.com/>
Availability: Algeria, Austria, Belgium, Bosnia and Herzegovina, Brazil, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Egypt, Faroe Islands, Finland, France, Germany, Greece, Hungary, Iceland, Italy, Libyan Arab Jamahiriya, Luxembourg, Mauritania, Morocco, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Tunisia, Turkey

Calsak Polymers
Telephone: 800-743-2595
Web: <http://www.calsakpolymers.com/>
Availability: North America

Distrupol Ltd
Distrupol Ltd is a Pan European distribution company. Contact Distrupol Ltd for availability of individual products by country.
Telephone: 08452003040
Web: <http://www.distrupol.com/>
Availability: Ireland, United Kingdom

Entec Polymers
Telephone: 800-375-5440
Web: <http://www.entecpolymers.com/>
Availability: North America

M. Holland Canada Company
Telephone: 905-665-1168
Web: <http://www.mholland.com/>
Availability: Canada

M. Holland Company
Telephone: 855-497-1403
Web: <http://www.mholland.com/>
Availability: Mexico, United States

Plastribution
Telephone: +44-845-345-4560
Web: <http://www.plastribution.co.uk/>
Availability: United Kingdom

The Materials Group
Telephone: 616-863-6046
Web: <http://thematerialsgroup.com/>
Availability: North America

