

# POLYLAC® PA-765

Acrylonitrile Butadiene Styrene  
CHI MEI CORPORATION



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## Technical Data

### General

Material Status	• Commercial: Active
Literature <sup>1</sup>	• Processing (English) • Technical Datasheet - ASTM (English) • Technical Datasheet - ISO (English)
UL Yellow Card <sup>2</sup>	• E56070-565073 • E56070-101317482
Search for UL Yellow Card	• CHI MEI CORPORATION • POLYLAC®
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding

Physical	Nominal Value Unit	Test Method
Specific Gravity	1.19 g/cm <sup>3</sup>	ASTM D792 ISO 1183
Melt Mass-Flow Rate (MFR)		ASTM D1238
200°C/5.0 kg	5.0 g/10 min	
220°C/10.0 kg	56 g/10 min	
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	49.0 cm <sup>3</sup> /10min	ISO 1133

Mechanical	Nominal Value Unit	Test Method
Tensile Stress		
Yield	39.0 MPa	ISO 527-2/50
Break	34.0 MPa	ISO 527-2/50
3.00 mm <sup>4</sup>	38.2 MPa	ASTM D638
Tensile Elongation		
Break, 3.00 mm <sup>4</sup>	15 %	ASTM D638
Break	10 %	ISO 527-2/50
Flexural Modulus		
6.00 mm <sup>5</sup>	2060 MPa	ASTM D790
-- <sup>6</sup>	1800 MPa	ISO 178
Flexural Strength		
6.00 mm <sup>5</sup>	60.8 MPa	ASTM D790
-- <sup>6</sup>	55.0 MPa	ISO 178

Impact	Nominal Value Unit	Test Method
Charpy Notched Impact Strength	20 kJ/m <sup>2</sup>	ISO 179
Notched Izod Impact		
23°C, 3.00 mm	220 J/m	ASTM D256
23°C, 6.00 mm	180 J/m	ASTM D256
--	17 kJ/m <sup>2</sup>	ISO 180/1A

Hardness	Nominal Value Unit	Test Method
Rockwell Hardness (R-Scale)	100	ASTM D785
Ball Indentation Hardness (H 358/30)	79.0 MPa	ISO 2039-1

Thermal	Nominal Value Unit	Test Method
Deflection Temperature Under Load		
1.8 MPa, Unannealed	73.0 °C	ASTM D648
1.8 MPa, Unannealed	74.0 °C	ISO 75-2/A
1.8 MPa, Annealed	83.0 °C	ASTM D648
1.8 MPa, Annealed	90.0 °C	ISO 75-2/A

Thermal	Nominal Value Unit	Test Method
Vicat Softening Temperature		
--	90.0 °C	ASTM D1525 <sup>7</sup> ISO 306/A50 <sup>7</sup>
--	78.0 °C	ISO 306/B50
Flammability	Nominal Value Unit	Test Method
Flame Rating		UL 94
1.00 mm	V-1	
1.50 mm	V-0	
1.60 mm	V-0	
2.50 mm	5VA	
Injection	Nominal Value Unit	
Drying Temperature	80.0 to 85.0 °C	
Drying Time	2.0 to 4.0 hr	
Rear Temperature	180 to 210 °C	
Middle Temperature	190 to 220 °C	
Front Temperature	190 to 220 °C	
Mold Temperature	40.0 to 70.0 °C	
Injection Pressure	4.90 to 7.85 MPa	
Injection Rate	Slow-Moderate	
Holding Pressure	1.96 to 4.90 MPa	
Back Pressure	0.490 to 0.981 MPa	
Cushion	3.18 mm	

**Notes**

- <sup>1</sup> These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.
- <sup>2</sup> A UL Yellow Card contains UL-verified flammability and electrical characteristics. UL IDES continually works to link Yellow Cards to individual plastic materials in Prospector, however this list may not include all of the appropriate links. It is important that you verify the association between these Yellow Cards and the plastic material found in Prospector. For a complete listing of Yellow Cards, visit the UL Yellow Card Search.
- <sup>3</sup> Typical properties: these are not to be construed as specifications.
- <sup>4</sup> 6.0 mm/min
- <sup>5</sup> 2.8 mm/min
- <sup>6</sup> 2.0 mm/min
- <sup>7</sup> Rate A (50°C/h)

## Where to Buy

### Supplier

#### **CHI MEI CORPORATION**

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

### Distributor

#### **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, 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

#### **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**

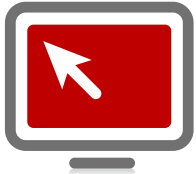
**Telephone:** +44-845-345-4560  
**Web:** <http://www.plastribution.co.uk/>  
**Availability:** United Kingdom

#### **The Materials Group**

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



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### Prospector Plastics Database - [www.ides.com/prospector](http://www.ides.com/prospector)

Prospector is a searchable online database that includes 85,000 data sheets from 875 manufacturers and 44,000 UL yellow cards. Each data sheet includes property, processing and supplier contact information. Prospector is relied on by nearly 400,000 design engineers and plastics processors. Using Prospector, they save time with plastic material selection by quickly and easily referencing technical information critical to the success of their products.

*"Prospector is absolutely the best and most well-known search engine for plastic raw materials in the world. We use Prospector every day – it's a real time saver!"*

– Birgit Elvardt Bader, Production Manager, Micotron

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**Alternative Resins Search** – find replacement plastics within minutes.

**Automotive Plastics Search** – easily locate automotive approved plastics.

**Curve Data** – view, overlay and export curve data.



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– Kevin Chase, Owner & President, Chase Plastics



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