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POLYLAC® PA-758

CHI MEI CORPORATION - Methyl Methacrylate / ABS

Thursday, January 31, 2019

General Information

Product Description	
Transparent	
General	
Material Status	• Commercial: Active
RoHS Compliance	• RoHS Compliant
Appearance	• Clear/Transparent
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• >MABS<

ASTM and ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.08	g/cm³	ASTM D792
Density (23°C)	1.08	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.0	g/10 min	ISO 1133
Molding Shrinkage	0.30 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2]	39.7	MPa	ASTM D638
Tensile Stress (Yield)	42.0	MPa	ISO 527-2/50
Tensile Stress (Break)	33.0	MPa	ISO 527-2/50
Tensile Elongation [2] (Break)	40	%	ASTM D638
Tensile Strain (Break)	40	%	ISO 527-2/50
Flexural Modulus [3]	1900	MPa	ASTM D790
Flexural Modulus [4]	1900	MPa	ISO 178
Flexural Strength [3]	53.9	MPa	ASTM D790
Flexural Stress [4]	57.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179
-30°C	7.0	kJ/m²	
23°C	14	kJ/m²	
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	150	J/m	
23°C, 6.40 mm	160	J/m	
Notched Izod Impact Strength			ISO 180/1A
-30°C	7.0	kJ/m²	
23°C	14	kJ/m²	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	107		ASTM D785

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed	88.0	°C	
Heat Deflection Temperature (1.8 MPa, Unannealed)	77.0	°C	ISO 75-2/A
Deflection Temperature Under Load (1.8 MPa, Annealed)	99.0	°C	ASTM D648
Heat Deflection Temperature (1.8 MPa, Annealed)	97.0	°C	ISO 75-2/A
Vicat Softening Temperature	105	°C	ASTM D1525 [5]
Vicat Softening Temperature			
--	104	°C	ISO 306/A50
--	96.0	°C	ISO 306/B50
CLTE - Flow	9.0E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	85	°C
Drying Time	3.0 to 5.0	hr
Rear Temperature	200 to 220	°C
Middle Temperature	220 to 250	°C
Front Temperature	220 to 250	°C
Processing (Melt) Temp	230 to 240	°C
Mold Temperature	50 to 70	°C
Injection Pressure	4.90 to 7.85	MPa
Holding Pressure	1.96 to 4.90	MPa
Back Pressure	0.490 to 0.981	MPa

Notes

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

[2] 6.0 mm/min

[3] 2.8 mm/min

[4] 2.0 mm/min

[5] Rate A (50°C/h), Loading 1 (10 N)