DISTRUPOL℠
A Univar company

POLYLAC® PA-717C

CHI MEI CORPORATION - Acrylonitrile Butadiene Styrene

Thursday, January 31, 2019

General Information

General	
Material Status	• Commercial: Active
Features	• Medium Impact Resistance
RoHS Compliance	• RoHS Compliant
Resin ID (ISO 1043)	• >ABS<

ASTM and ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity [2]	1.04	g/cm³	ASTM D792
Density (23°C)	1.04	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.3	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	16.0	cm³/10min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [3] (Yield)	42.1	MPa	ASTM D638
Tensile Stress (Yield)	44.0	MPa	ISO 527-2/50
Tensile Stress (Break)	33.0	MPa	ISO 527-2/50
Tensile Elongation [3] (Break)	30	%	ASTM D638
Tensile Strain (Break)	30	%	ISO 527-2/50
Flexural Modulus [4]	2410	MPa	ASTM D790
Flexural Modulus [5]	1900	MPa	ISO 178
Flexural Strength [4]	70.3	MPa	ASTM D790
Flexural Stress [5]	69.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179
-30°C	13	kJ/m²	
23°C	27	kJ/m²	
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	290	J/m	
23°C, 6.40 mm	250	J/m	
Notched Izod Impact Strength			ISO 180/1A
-30°C	12	kJ/m²	
23°C	25	kJ/m²	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	115		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed	85.0	°C	
Heat Deflection Temperature (1.8 MPa, Unannealed)	82.0	°C	ISO 75-2/A
Deflection Temperature Under Load (1.8 MPa, Annealed)	95.0	°C	ASTM D648
Heat Deflection Temperature (1.8 MPa, Annealed)	97.0	°C	ISO 75-2/A

POLYLAC® PA-717C

CHI MEI CORPORATION - Acrylonitrile Butadiene Styrene

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	104	°C	ASTM D1525 [6]
Vicat Softening Temperature			
--	103	°C	ISO 306/A50
--	98.0	°C	ISO 306/B50
CLTE - Flow	8.8E-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	80 to 85	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	180 to 220	°C
Middle Temperature	190 to 230	°C
Front Temperature	190 to 230	°C
Mold Temperature	30 to 70	°C

Notes

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

[2] 23°C

[3] 6.0 mm/min

[4] 2.8 mm/min

[5] 2.0 mm/min

[6] Rate A (50°C/h), Loading 1 (10 N)