



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 Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.04	g/cm ³	ASTM D792
Density (23°C)	1.04	g/cm ³	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	cm ³ /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/m ²	
23°C	27	kJ/m ²	
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/m ²	
23°C	25	kJ/m ²	
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

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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)