



**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<sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity <sup>2</sup>	1.04	g/cm <sup>3</sup>	ASTM D792
Density (23°C)	1.04	g/cm <sup>3</sup>	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 <sup>3</sup> /10min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>3</sup> (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 <sup>3</sup> (Break)	30	%	ASTM D638
Tensile Strain (Break)	30	%	ISO 527-2/50
Flexural Modulus <sup>4</sup>	2410	MPa	ASTM D790
Flexural Modulus <sup>5</sup>	1900	MPa	ISO 178
Flexural Strength <sup>4</sup>	70.3	MPa	ASTM D790
Flexural Stress <sup>5</sup>	69.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	13	kJ/m <sup>2</sup>	
23°C	27	kJ/m <sup>2</sup>	
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 <sup>2</sup>	
23°C	25	kJ/m <sup>2</sup>	

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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<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Vicat Softening Temperature	104	°C	ASTM D1525 <sup>6</sup>
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
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (1.5 mm)	HB		UL 94

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 23°C

<sup>3</sup> 6.0 mm/min

<sup>4</sup> 2.8 mm/min

<sup>5</sup> 2.0 mm/min

<sup>6</sup> Rate A (50°C/h), Loading 1 (10 N)