

Properties

A1500

PA/ABS resin (UL94 HB)

Properties	Test methods	Test conditions	Units	Dry	2.0% moist.
Mold shrinkage	ASTM D955	-	%	0.6-0.8	-
Tensile strength	ISO 527	-	MPa	42	33
Flexural strength	ISO 178	-	MPa	62	44
Flexural modulus	ISO 178	-	MPa	1800	1200
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m ²	83	78
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m ²	16	-
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	830	850
Notched Izod impact strength	ASTM D256	-30 deg C/6.4mm	J/m	160	-
Rockwell hardness	ISO 2039	-	-	R108	R101
Deflection temperature under load	ISO 75	1.80MPa	deg C	74	70
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	84	80
Deflection temperature under load	ISO 75	0.45MPa	deg C	100	90
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	100	92
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	10	-
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-	-
Flammability	UL94	-	-	HB	-
Water absorption	ISO 62	-	%	0.7	-
Density	ISO 1183	-	g/cm ³	1.06	-

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
4-5hrs 90-100deg C	220-250	230-260	220-250	180-210	60-90	10-20	60-70