

## Properties

### A1500

PA/ABS resin

Properties	Test methods	Test conditions	Units	Dry	2.0% moist.
Mold shrinkage	Daicel method	-	%	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 <sup>2</sup>	83	78
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m <sup>2</sup>	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 <sup>3</sup>	1.06	-

**Note**

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.
- UL recognition File No. is E47773.
- The colorant formulations are restricted for each UL certified color. Please contact us for more information.

### 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