

Cycolac* Resin GSM

Americas: LIMITED USE

ABS, injection moulding, impact grade. Excellent surface appearance, good toughness and impact resistance. Excellent flow and chemical resistance.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	43	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	73	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2270	MPa	ASTM D 790
Hardness, Rockwell R	105	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	373	J/m	ASTM D 256
Izod Impact, notched, -40°C	106	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.54E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	2.5	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	2050	poise	ASTM D 3825
ELECTRICAL			
Volume Resistivity	3.7E+15	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	16.8	kV/mm	ASTM D 149
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED
Oxygen Index (LOI)	19	%	ASTM D 2863
UV-light, water exposure/immersion	F2	-	UL 746C

Source GMD, last updated:12/29/1999

Processing

Parameter	Value	Unit
Injection Molding		

Drying Temperature	80 - 95	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	230 - 260	°C
Nozzle Temperature	230 - 260	°C
Front - Zone 3 Temperature	225 - 245	°C
Middle - Zone 2 Temperature	210 - 225	°C
Rear - Zone 1 Temperature	190 - 205	°C
Mold Temperature	50 - 70	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	30 - 60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.051	mm

Source GMD, last updated:12/29/1999

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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