CYCOLAC™ RESIN GRM2600L

REGION AMERICAS

DESCRIPTION

High Impact , good chemical resistance sheet grade ABS designed for refrigerator liner applications.

TYPICAL PROPERTY VALUES

Revision 20190703

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	41	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	35	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	55	%	ASTM D 638
Tensile Modulus, 5 mm/min	2410	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	400	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	46	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	113	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	100	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.45 – 0.65	%	SABIC method
Melt Flow Rate, 220°C/10.0 kgf	2.5	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220708	-	-
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	230 – 275	°C	
Nozzle Temperature	230 – 275	°C	
Front - Zone 3 Temperature	230 – 255	°C	
Middle - Zone 2 Temperature	210 – 225	°C	
Rear - Zone 1 Temperature	195 – 210	°C	
Mold Temperature	50 – 80	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	
Shot to Cylinder Size	50 – 70	%	

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Vent Depth	0.038 – 0.051	mm	
SHEET EXTRUSION			
Drying Temperature	80 – 95	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	215 – 260	°C	
Barrel - Zone 1 Temperature	170 – 200	°C	
Barrel - Zone 2 Temperature	180 – 220	°C	
Barrel - Zone 3 Temperature	190 – 225	°C	
Barrel - Zone 4 Temperature	200 – 240	°C	
Adapter Temperature	205 – 250	°C	
Die Temperature	205 – 250	°C	
Roll Stack Temp - Top	90 – 95	°C	
Roll Stack Temp - Middle	95 – 105	°C	
Roll Stack Temp - Bottom	100 – 105	°C	

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