CYCOLAC™ RESIN MG94

REGION ASIA

DESCRIPTION

Superior flow, injection molding ABS. Good impact. For thin-wall applications.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	46	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	35	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	18	%	ASTM D 638
Tensile Modulus, 5 mm/min	2480	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	79	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2620	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	240	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	21	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	95	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.82E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.46E-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 kg	11.7	g/10 min	ASTM D 1238
Melt Viscosity, 240°C, 1000 sec-1	1720	Poise	ASTM D 3825
Melt Flow Rate, 220°C/5.0 kg	12	g/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Yellow Card Link	E207780-256888	-	-
UL Recognized, 94HB Flame Class Rating	1.52	mm	UL 94
INJECTION MOLDING			
Drying Temperature	80 – 90	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	205 – 245	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	205 – 245	°C	
Front - Zone 3 Temperature	205 – 225	°C	
Middle - Zone 2 Temperature	200 – 210	°C	
Rear - Zone 1 Temperature	190 – 200	°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	

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