

CYCOLACTM RESIN MG29

REGION ASIA

DESCRIPTION

Super high impact ABS. Good low temperature toughness.

TYPICAL PROPERTY VALUES

Revision 20190207

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	39	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	31	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	26	%	ASTM D 638
Tensile Modulus, 5 mm/min	2000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	65	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2070	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	42	MPa	ISO 527
Tensile Stress, break, 50 mm/min	32	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.8	%	ISO 527
Tensile Strain, break, 50 mm/min	20	%	ISO 527
Tensile Modulus, 1 mm/min	2050	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	61	MPa	ISO 178
Flexural Modulus, 2 mm/min	1990	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	455	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	29	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	37	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	12	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	99	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	79	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.54E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.36E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	98	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	79	°C	ISO 75/Af
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	1.2	g/10 min	ASTM D 1238

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Viscosity, 240°C, 1000 sec-1	2800	Poise	ASTM D 3825
Melt Flow Rate, 220°C/10.0 kg	8	g/10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	0	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	230 – 275	°C	
Nozzle Temperature	230 – 275	°C	
Front - Zone 3 Temperature	225 – 240	°C	
Middle - Zone 2 Temperature	210 – 220	°C	
Rear - Zone 1 Temperature	190 – 200	°C	
Mold Temperature	50 – 65	°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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