

# CYCOLAC<sup>TM</sup> RESIN MG38F

REGION ASIA

## DESCRIPTION

Very high impact ABS. Toughness/rigidity. FDA compliant.

## TYPICAL PROPERTY VALUES

Revision 20190207

| PROPERTIES                                   | TYPICAL VALUES | UNITS    | TEST METHODS |
|--|----------------|----------|--------------|
| <b>MECHANICAL</b>                            |                |          |              |
| Tensile Stress, yld, Type I, 5 mm/min        | 43             | MPa      | ASTM D 638   |
| Tensile Stress, brk, Type I, 5 mm/min        | 33             | MPa      | ASTM D 638   |
| Tensile Strain, yld, Type I, 5 mm/min        | 2.1            | %        | ASTM D 638   |
| Tensile Strain, brk, Type I, 5 mm/min        | 26             | %        | ASTM D 638   |
| Tensile Modulus, 5 mm/min                    | 2130           | MPa      | ASTM D 638   |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 68             | MPa      | ASTM D 790   |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 2200           | MPa      | ASTM D 790   |
| <b>IMPACT</b>                                |                |          |              |
| Izod Impact, notched, 23°C                   | 373            | J/m      | ASTM D 256   |
| Instrumented Impact Total Energy, 23°C       | 31             | J        | ASTM D 3763  |
| <b>THERMAL</b>                               |                |          |              |
| Vicat Softening Temp, Rate B/50              | 98             | °C       | ASTM D 1525  |
| HDT, 0.45 MPa, 3.2 mm, unannealed            | 97             | °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                    | 8.64E-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      |
| <b>PHYSICAL</b>                              |                |          |              |
| Specific Gravity                             | 1.05           | -        | ASTM D 792   |
| Mold Shrinkage, flow, 3.2 mm                 | 0.5 – 0.8      | %        | SABIC method |
| Melt Flow Rate, 230°C/3.8 kg                 | 3.7            | g/10 min | ASTM D 1238  |
| Melt Viscosity, 240°C, 1000 sec-1            | 2450           | Poise    | ASTM D 3825  |
| Melt Flow Rate, 220°C/10.0 kg                | 15             | g/10 min | ISO 1133     |
| <b>ELECTRICAL</b>                            |                |          |              |
| 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}            | 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      |
| <b>FLAME CHARACTERISTICS</b>                 |                |          |              |
| UL Recognized, 94HB Flame Class Rating       | 1.52           | mm       | UL 94        |
| <b>INJECTION MOLDING</b>                     |                |          |              |

| PROPERTIES                  | TYPICAL VALUES | UNITS | TEST METHODS |
|-----------------------------|----------------|-------|--------------|
| Drying Temperature          | 80 – 95        | °C    |              |
| Drying Time                 | 2 – 4          | hrs   |              |
| Drying Time (Cumulative)    | 8              | hrs   |              |
| Maximum Moisture Content    | 0.1            | %     |              |
| Melt Temperature            | 220 – 260      | °C    |              |
| Nozzle Temperature          | 220 – 260      | °C    |              |
| Front - Zone 3 Temperature  | 215 – 240      | °C    |              |
| Middle - Zone 2 Temperature | 205 – 225      | °C    |              |
| Rear - Zone 1 Temperature   | 190 – 210      | °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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