SABIC Innovative Plastics™

sabic

Cycolac* Resin AS35

Asia Pacific: COMMERCIAL

High flow, medium impact grade of ABS.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	450	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	15	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	640	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	20	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	77	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	86	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 230°C/5 kgf	18	g/10 min	ASTM D 1238

1) Typical values only. Variations within normal tolerances are possible for variose colours.All values are measured at least after 48 hours storage at 230C/50% relative humidity.
All properties, expect the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose.Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
4) Own measurement according to UL.
5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 85	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Melt Temperature	220 - 240	°C
Mold Temperature	50 - 70	°C

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