+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

CYCOLAC™ Resin EX75

Asia Pacific: COMMERCIAL

Multi-purpose, extrusion ABS providing a favorable balance of engineering properties.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	400	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	330	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	42.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	21700	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	740	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24500	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	43	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	357	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	106	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.92E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.1E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Viscosity, 240°C, 100 sec-1	11600	poise	ASTM D 3825
Melt Volume Rate, MVR at 220°C/10.0 kg	9	cm³/10 min	ISO 1133

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(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.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA.

+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

CYCOLAC™ Resin EX75

Asia Pacific: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Sheet Extrusion		
Drying Temperature	90 - 95	°C
Drying Time (Cumulative)	4	hrs
Maximum Moisture Content	0	%
Melt Temperature	200 - 220	°C
Barrel - Zone 1 Temperature	170 - 190	°C
Barrel - Zone 2 Temperature	180 - 200	°C
Barrel - Zone 3 Temperature	175 - 205	°C
Barrel - Zone 4 Temperature	180 - 210	°C
Adapter Temperature	180 - 205	°C
Die Temperature	180 - 215	°C

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(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.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated: