



CYCOLAC™ RESIN GRM2600L

REGION AMERICAS

DESCRIPTION

High Impact , good chemical resistance sheet grade ABS designed for refrigerator liner applications.

TYPICAL PROPERTY VALUES

Revision 20170816

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|--|----------------|----------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 5 mm/min | 41 | MPa | ASTM D 638 |
| Tensile Stress, brk, Type I, 5 mm/min | 35 | MPa | ASTM D 638 |
| Tensile Strain, brk, Type I, 5 mm/min | 55 | % | ASTM D 638 |
| Tensile Modulus, 5 mm/min | 2410 | MPa | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 75 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 2300 | MPa | ASTM D 790 |
| IMPACT | | | |
| Izod Impact, notched, 23°C | 400 | J/m | ASTM D 256 |
| Instrumented Impact Total Energy, 23°C | 46 | J | ASTM D 3763 |
| THERMAL | | | |
| Vicat Softening Temp, Rate B/50 | 113 | °C | ASTM D 1525 |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 100 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 85 | °C | ASTM D 648 |
| CTE, -40°C to 40°C, xflow | 7.2E-05 | 1/°C | ASTM E 831 |
| PHYSICAL | | | |
| Specific Gravity | 1.04 | - | ASTM D 792 |
| Mold Shrinkage, flow, 3.2 mm (5) | 0.45 – 0.65 | % | SABIC method |
| Melt Flow Rate, 220°C/10.0 kgf | 2.5 | g/10 min | ASTM D 1238 |
| INJECTION MOLDING | | | |
| Drying Temperature | 90 – 95 | °C | |
| Drying Time | 2 – 4 | hrs | |
| Drying Time (Cumulative) | 8 | hrs | |
| Maximum Moisture Content | 0.01 | % | |
| Melt Temperature | 230 – 275 | °C | |
| Nozzle Temperature | 230 – 275 | °C | |



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|-----------------------------|----------------|-------|--------------|
| Front - Zone 3 Temperature | 230 – 255 | °C | |
| Middle - Zone 2 Temperature | 210 – 225 | °C | |
| Rear - Zone 1 Temperature | 195 – 210 | °C | |
| Mold Temperature | 50 – 80 | °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 | |

DISCLAIMER

The information contained herein may include typical properties of our products or their typical performances when used in certain typical applications. Actual properties of our products, in particular when used in conjunction with any third party material(s) or for any non-typical applications, may differ from typical properties.

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Nothing herein is intended to be nor shall it constitute a warranty whatsoever, in particular, warranty of merchantability or fitness for a particular purpose.

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