



Cycolac* Resin MG94MD

Asia Pacific: COMMERCIAL

Superior flow, injection molding ABS. Good impact. For thin-wall applications. ISO 10993 (levels 1 and 2 only) and FDA compliant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	470	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	360	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	18	%	ASTM D 638
Tensile Modulus, 5 mm/min	25300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	800	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	24	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	214	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	95	°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	8.46E-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
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 kgf	11.7	g/10 min	ASTM D 1238
Melt Viscosity, 240°C, 1000 sec-1	1720	poise	ASTM D 3825

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.
All properties, except 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.





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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
PHYSICAL Melt Flow Rate, 220°C/5.0 kg	12	g/10 min	ISO 1133
FLAME CHARACTERISTICS UL Recognized, 94HB Flame Class Rating (3)	1.52	mm	UL 94

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Source, GMD, Last Update:





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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	205 - 245	°C
Nozzle Temperature	205 - 245	°C
Front - Zone 3 Temperature	205 - 225	°C
Middle - Zone 2 Temperature	200 - 210	°C
Rear - Zone 1 Temperature	190 - 200	°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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