

CYCOLAC™ RESIN MG94

REGION EUROPE

DESCRIPTION

Superior flow, injection molding ABS. Good impact. For thin-wall applications.

TYPICAL PROPERTY VALUES

Revision 20170816

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	40	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	35	%	ISO 527
Tensile Strain, yield, 50 mm/min	2.2	%	ISO 527
Tensile Strain, break, 50 mm/min	45	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	2450	MPa	ISO 178
Hardness, H358/30	95	MPa	ISO 2039-1
Hardness, Rockwell R	129	-	ISO 2039-2
IMPACT			
Izod Impact, notched 80*10*4 +23°C	18	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	23	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, 23°C to 60°C, flow	8.7E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.7E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	99	°C	ISO 306
Vicat Softening Temp, Rate B/120	100	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	91	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	80	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 – 0.7	%	SABIC method



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Density	1.04	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.16	%	ISO 62
Melt Volume Rate, MVR at 220°C/10.0 kg	39	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 650°C, passes at	3.2	mm	IEC 60695-2-12
INJECTION MOLDING			
Drying Temperature	85 – 95	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	220 – 260	°C	
Nozzle Temperature	210 – 250	°C	
Front - Zone 3 Temperature	220 – 260	°C	
Middle - Zone 2 Temperature	220 – 260	°C	
Rear - Zone 1 Temperature	200 – 240	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	40 – 80	°C	

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.

It is the customer's responsibility to inspect and test our product(s) in order to satisfy itself as to the suitability of the product(s) for its and its customers particular purposes. The customer is responsible for the appropriate, safe and legal use, processing and handling of all product(s) purchased from us.

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

SABIC as referred to herein means any legal entity belonging to the group of companies headed by Saudi Arabia Basic Industries Corporation.

