



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/cm ²	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/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm ²	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



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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