



Cycolac* Resin MG37EP

Americas: COMMERCIAL

Injection molding abs, especially for electroplating/painting applications requiring excellent flow and aesthetics.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	430	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	340	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	30	%	ASTM D 638
Tensile Modulus, 5 mm/min	24200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	740	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24900	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.4	%	ISO 527
Tensile Strain, break, 50 mm/min	42.8	%	ISO 527
IMPACT			
Izod Impact, notched, 23°C	35	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	350	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	31	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	34	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	101	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	98	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.74E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.38E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	96	°C	ISO 306



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Vicat Softening Temp, Rate B/120	98	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	79	°C	ISO 75/Af
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	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	4.4	g/10 min	ASTM D 1238
Melt Viscosity, 240°C, 1000 sec-1	2550	poise	ASTM D 3825
Density	1.04	g/cm ³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	16	g/10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.52	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 95	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 280	°C
Nozzle Temperature	255 - 280	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	230 - 245	°C
Rear - Zone 1 Temperature	215 - 230	°C
Mold Temperature	40 - 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