CYCOLAC™ RESIN EX75

REGION ASIA

DESCRIPTION

Multi-purpose, extrusion ABS providing a favorable balance of engineering properties.

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	39	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	33	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	42.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	2130	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	73	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	421	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	35	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	106	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.92E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.1E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Viscosity, 240°C, 100 sec-1	11600	Poise	ASTM D 3825
Melt Volume Rate, MVR at 220°C/10.0 kg	9	cm³/10 min	ISO 1133
SHEET EXTRUSION			
Drying Temperature	90 – 95	°C	
Drying Time (Cumulative)	4	hrs	
Maximum Moisture Content	0	%	
Melt Temperature	200 – 220	°C	
Barrel - Zone 1 Temperature	170 – 190	°C	
Barrel - Zone 2 Temperature	180 – 200	°C	
Barrel - Zone 3 Temperature	175 – 205	°C	
Barrel - Zone 4 Temperature	180 – 210	°C	
Adapter Temperature	180 – 205	°C	
Die Temperature	180 – 215	°C	

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