

CYCOLAC™ HMG47MD resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

General purpose, injection molding ABS for medical applications. Biocompatible (ISO10993). FDA compliant. Gamma & EtO sterilizable.

General Information			
Features	Radiation disinfection		
	Ethylene oxide disinfection		
	Biocompatibility		
	Compliance of Food Exposure		
	General		
Uses	General		
	Medical/nursing supplies		
Agency Ratings	FDA not rated		
	ISO 10993		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/3.8 kg	5.6	g/10 min	ASTM D1238
220°C/10.0 kg	19	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2280	MPa	ASTM D638
--	2530	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	44.1	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/5
Fracture ³	33.8	MPa	ASTM D638
Fracture	35.3	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.0	%	ASTM D638
Yield	2.6	%	ISO 527-2/5
Fracture ⁵	24	%	ASTM D638

Fracture	25	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	2340	MPa	ASTM D790
-- ⁷	2410	MPa	ISO 178
Flexural Stress			
--	76.0	MPa	ISO 178
Yield, 50.0mm span ⁸	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	130	J/m	ASTM D256
23°C	320	J/m	ASTM D256
-30°C ⁹	8.5	kJ/m ²	ISO 180/1A
23°C ¹⁰	23	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	31.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	94.0	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	80.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	80.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	98.0	°C	ASTM D1525 ¹²
--	100	°C	ISO 306/B50
Linear thermal expansion coefficient			ISO 11359-2
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	8.8E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	50 - 70	%	
Rear Temperature	188 - 210	°C	
Middle Temperature	204 - 227	°C	
Front Temperature	216 - 238	°C	
Nozzle Temperature	218 - 260	°C	
Processing (Melt) Temp	218 - 260	°C	
Mold Temperature	48.9 - 71.1	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	30 - 60	rpm	
Vent Depth	0.038 - 0.051	mm	
NOTE			

1.	5.0 mm/min
2.	Type 1, 5.0 mm/min
3.	Type 1, 5.0 mm/min
4.	Type 1, 5.0 mm/min
5.	Type 1, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	80*10*4
11.	80*10*4 mm
12.	标准 B (120°C/h), 载荷2 (50N)

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