

CYCOLAC™ EX75 resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

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

General Information			
UL YellowCard	E121562-220685		
Processing Method	Sheet extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2140	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	40.0	MPa	ASTM D638
Fracture	33.1	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	2.4	%	ASTM D638
Fracture	43	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2410	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	73.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	420	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	35.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	94.4	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	82.2	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.9E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	8.1E-5	cm/cm/°C	ASTM E831
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (240°C, 100 sec ⁻¹)	1160	Pa · s	ASTM D3835
Extrusion	Nominal Value	Unit	
Drying Temperature	87.8 - 93.3	°C	
Suggested Max Moisture	1.0E-3	%	

Cylinder Zone 1 Temp.	171 - 188	°C
Cylinder Zone 2 Temp.	182 - 199	°C
Cylinder Zone 3 Temp.	177 - 204	°C
Cylinder Zone 4 Temp.	179 - 210	°C
Adapter Temperature	179 - 204	°C
Melt Temperature	199 - 218	°C
Die Temperature	179 - 216	°C

Extrusion instructions

Drying Time (Cumulative): 4 hrs

NOTE

1.	5.0 mm/min
2.	Type 1, 5.0 mm/min
3.	Type 1, 5.0 mm/min
4.	1.3 mm/min
5.	1.3 mm/min
6.	标准 B (120°C/h), 载荷2 (50N)

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