

CYCOLOY™ EX39F resin

Acrylonitrile Butadiene Styrene
SABIC Innovative Plastics Asia Pacific

Message:
Highest impact extrusion ABS for sheet and blow molding applications. FDA food contact compliant.

General Information			
Features	Food Contact Acceptable		
	High Impact Resistance		
Uses	Blow Molding Applications		
	Sheet		
Agency Ratings	FDA Food Contact, Unspecified Rating		
Processing Method	Sheet Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	4.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.70 to 0.90	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	1680	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	35.9	MPa	
Break	29.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	3.5	%	
Break	110	%	
Flexural Modulus ⁴ (50.0 mm Span)	1900	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	57.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	320	J/m	
23°C	460	J/m	
Instrumented Dart Impact (23°C, Total Energy)	39.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	91.7	°C	
1.8 MPa, Unannealed, 3.20 mm	77.8	°C	
Vicat Softening Temperature	106	°C	ASTM D1525 ⁶

CLTE			ASTM E831
Flow : -40 to 40°C	1.0E-4	cm/cm/°C	
Transverse : -40 to 40°C	1.2E-4	cm/cm/°C	
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.52 mm)	HB		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (240°C, 100 sec^-1)	1520	Pa·s	ASTM D3835
Extrusion	Nominal Value	Unit	
Drying Temperature	87.8 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	1.0E-3	%	
Cylinder Zone 1 Temp.	193 to 210	°C	
Cylinder Zone 2 Temp.	199 to 221	°C	
Cylinder Zone 3 Temp.	204 to 232	°C	
Cylinder Zone 4 Temp.	210 to 235	°C	
Adapter Temperature	199 to 227	°C	
Melt Temperature	210 to 241	°C	
Die Temperature	210 to 241	°C	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	Rate B (120°C/h), Loading 2 (50 N)		

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