

CYCOLAC™ MG94 resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

Superior flow, injection molding ABS. Good impact. For thin-wall applications.

General Information			
UL YellowCard	E207780-256888		
Features	Impact resistance, good		
	Good liquidity		
Uses	Thin wall parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			
230°C/3.8 kg	12	g/10 min	ASTM D1238
220°C/5.0 kg	13	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	2480	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	46.9	MPa	ASTM D638
Fracture	35.9	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	2.0	%	ASTM D638
Fracture	18	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2620	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	79.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	240	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	21.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	95.6	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	82.2	°C	ASTM D648
Vicat Softening Temperature	98.9	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831

Lateral: -40 to 40°C	8.5E-5	cm/cm/°C	ASTM E831
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI	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, 1000 sec^-1)	173	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 87.8	°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 - 199	°C	
Middle Temperature	199 - 210	°C	
Front Temperature	204 - 227	°C	
Nozzle Temperature	204 - 246	°C	
Processing (Melt) Temp	204 - 246	°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.	1.3 mm/min		
5.	1.3 mm/min		
6.	标准 B (120°C/h), 载荷2 (50N)		

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