

CYCOLOY™ EX58 resin

Acrylonitrile Butadiene Styrene
SABIC Innovative Plastics Asia Pacific

Message:
High impact ABS for sheet extrusion and blow molding applications.

General Information			
Features	Impact resistance, high		
Uses	Blow molding applications		
	Sheet		
Processing Method	Sheet extrusion molding		
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)	4.20	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.60 - 0.80	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2080	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	40.0	MPa	ASTM D638
Fracture	30.3	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	3.1	%	ASTM D638
Fracture	32	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2160	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	66.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	300	J/m	ASTM D256
23°C	430	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	37.3	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	93.3	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	80.6	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	1.0E-4	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	1.0E-4	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
Electrical	Nominal Value		Test Method
Arc Resistance ⁷	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 0		UL 746
High Amp Arc Ignition (HAI)	PLC 4		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 1		UL 746
Hot-wire Ignition (HWI)	PLC 4		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)	1400	Pa·s	ASTM D3835
Extrusion	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Cylinder Zone 1 Temp.	171 - 199	°C	
Cylinder Zone 2 Temp.	182 - 221	°C	
Cylinder Zone 3 Temp.	188 - 227	°C	
Cylinder Zone 4 Temp.	199 - 238	°C	
Adapter Temperature	204 - 249	°C	
Melt Temperature	216 - 260	°C	
Die Temperature	204 - 249	°C	
Extrusion instructions			
Roll Stack Temp - Bottom: 99 - 104 °C Roll Stack Temp - Middle: 93 - 104 °C Roll Stack Temp - Top: 88 - 93 °C			
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)		
7.	Tungsten electrode		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

