



CYCOLAC™ Resin EX75
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	400	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	330	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	42.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	21700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	740	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24500	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	43	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	357	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	106	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.92E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.1E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Viscosity, 240°C, 100 sec-1	11600	poise	ASTM D 3825
Melt Volume Rate, MVR at 220°C/10.0 kg	9	cm ³ /10 min	ISO 1133





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Sheet Extrusion		
Drying Temperature	90 - 95	°C
Drying Time (Cumulative)	4	hrs
Maximum Moisture Content	0	%
Melt Temperature	200 - 220	°C
Barrel - Zone 1 Temperature	170 - 190	°C
Barrel - Zone 2 Temperature	180 - 200	°C
Barrel - Zone 3 Temperature	175 - 205	°C
Barrel - Zone 4 Temperature	180 - 210	°C
Adapter Temperature	180 - 205	°C
Die Temperature	180 - 215	°C

