



CYCOLAC™ Resin MGABS01
Americas: COMMERCIAL

Injection molding ABS. High impact, high gloss, good flow.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	420	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	320	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.1	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	26	%	ASTM D 638
Tensile Modulus, 5 mm/min	21000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	690	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	35	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	316	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	97	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.82E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.64E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	3.7	g/10 min	ASTM D 1238
Melt Viscosity, 240°C, 1000 sec-1	2450	poise	ASTM D 3825





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PHYSICAL			
Melt Volume Rate, MVR at 220°C/10.0 kg	15	cm ³ /10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.52	mm	UL 94





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 95	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	220 - 260	°C
Nozzle Temperature	220 - 260	°C
Front - Zone 3 Temperature	215 - 240	°C
Middle - Zone 2 Temperature	205 - 225	°C
Rear - Zone 1 Temperature	190 - 210	°C
Mold Temperature	50 - 70	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	30 - 60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.051	mm

