

Cycology* Resin MC8100
Americas: COMMERCIAL

Extrusion blowmolding grade.

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | UNIT | STANDARD |
|--|---------------|---------------------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 50 mm/min | 530 | kgf/cm ² | ASTM D 638 |
| Tensile Strain, yld, Type I, 50 mm/min | 5 | % | ASTM D 638 |
| Tensile Strain, brk, Type I, 50 mm/min | 100 | % | ASTM D 638 |
| Tensile Modulus, 50 mm/min | 21000 | kgf/cm ² | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 780 | kgf/cm ² | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 21000 | kgf/cm ² | ASTM D 790 |
| IMPACT | | | |
| Izod Impact, notched, 23°C | 54 | cm-kgf/cm | ASTM D 256 |
| Izod Impact, notched, -30°C | 43 | cm-kgf/cm | ASTM D 256 |
| Instrumented Impact Total Energy, 23°C | 553 | cm-kgf | ASTM D 3763 |
| Instrumented Impact Total Energy, -30°C | 483 | cm-kgf | ASTM D 3763 |
| THERMAL | | | |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 123 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 104 | °C | ASTM D 648 |
| CTE, -40°C to 40°C, flow | 8.1E-05 | 1/°C | ASTM E 831 |
| Thermal Conductivity | 0.2 | W/m-°C | ASTM C 177 |
| PHYSICAL | | | |
| Specific Gravity | 1.13 | - | ASTM D 792 |
| Water Absorption, 24 hours | 0.1 | % | ASTM D 570 |
| Water Absorption, equilibrium, 23C | 0.4 | % | ASTM D 570 |
| Mold Shrinkage, flow, 3.2 mm (5) | 0.4 - 0.7 | % | SABIC Method |

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

² Only typical data for material selection purpose. Not to be used for part or tool design.
³ This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
⁴ Own measurement according to UL.
⁵ Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

SABIC
Innovative
Plastics™



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| PROCESSING PARAMETERS | TYPICAL VALUE | UNIT |
|------------------------------------|---------------|------|
| Extrusion Blow Molding | | |
| Drying Temperature | 100 - 110 | °C |
| Drying Time | 3 - 4 | hrs |
| Drying Time (Cumulative) | 24 | hrs |
| Maximum Moisture Content | 0.04 - 0.05 | % |
| Minimum Moisture Content | 0.04 | % |
| Melt Temperature (Parison) | 245 - 260 | °C |
| Barrel - Zone 1 Temperature | 240 - 250 | °C |
| Barrel - Zone 2 Temperature | 240 - 255 | °C |
| Barrel - Zone 3 Temperature | 240 - 255 | °C |
| Barrel - Zone 4 Temperature | 240 - 255 | °C |
| Adapter - Zone 5 Temperature | 245 - 260 | °C |
| Head - Zone 6 - Top Temperature | 245 - 260 | °C |
| Head - Zone 7 - Bottom Temperature | 245 - 260 | °C |
| Screw Speed | 20 - 50 | rpm |
| Extruder Feed Zone Temperature | 60 - 80 | °C |
| Mold Temperature | 40 - 90 | °C |
| Die Temperature | 250 - 265 | °C |

• For extended downtime, lower barrel, head and die temperatures to 120°C (250°F).

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5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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