SABIC Innovative Plastics™

Cycolac* Resin EXABS01

Americas: COMMERCIAL

Sheet extrusion ABS with medium impact.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	400	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	290	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.1	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	31.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	20700	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	640	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21400	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	41	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	28	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	339	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	93	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.01E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.04E-04	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	1.03	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Viscosity, 240°C, 100 sec-1	14000	poise	ASTM D 3825

1) Typical values only. Variations within normal tolerances are possible for variose colours.All values are measured at least after 48 hours storage at 230C/50% relative humidity.
All properties, expect 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.

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TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
PHYSICAL			
Melt Volume Rate, MVR at 220°C/10.0 kg	4	cm³/10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	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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- Recommend initial lower temperatures settings to avoid material degradation/hang-up in die.
- Maintain melt temperature within processing range.

PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Extrusion Blow Molding		
Drying Temperature	80 - 90	°C
Drying Time	4 - 5	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature (Parison)	215 - 230	°C
Barrel - Zone 1 Temperature	205 - 225	°C
Barrel - Zone 2 Temperature	205 - 225	°C
Barrel - Zone 3 Temperature	205 - 225	°C
Barrel - Zone 4 Temperature	205 - 225	°C
Adapter - Zone 5 Temperature	210 - 230	°C
Head - Zone 6 - Top Temperature	215 - 230	°C
Head - Zone 7 - Bottom Temperature	215 - 230	°C
Screw Speed	20 - 60	rpm
Extruder Feed Zone Temperature	60 - 75	°C
Mold Temperature	40 - 80	°C
Die Temperature	215 - 235	°C
Sheet Extrusion		
Drying Temperature	80 - 95	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	215 - 260	°C
Barrel - Zone 1 Temperature	170 - 200	°C
Barrel - Zone 2 Temperature	180 - 220	°C
Barrel - Zone 3 Temperature	190 - 225	°C
Barrel - Zone 4 Temperature	200 - 240	°C
Adapter Temperature	205 - 250	°C
Die Temperature	205 - 250	°C
Roll Stack Temp - Top	90 - 95	°C

- Purge material from extruder prior to shutdown.
- For extended downtime, lower barrel, head and die temperatures to 95°C (200°F).

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Sheet Extrusion		
Roll Stack Temp - Middle	95 - 105	°C
Roll Stack Temp - Bottom	100 - 105	°C

• Purge material from extruder prior to shutdown.
• For extended downtime, lower barrel, head and die temperatures to 95°C (200°F).

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