

CYCOLAC™ MG37EPX resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

ABS plating grade optimized for a broad processing window for both painted and plated applications.

General Information			
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.60	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	48.5	MPa	ISO 527-2/5
Fracture	39.6	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	2.1	%	ISO 527-2/5
Fracture	16	%	ISO 527-2/5
Flexural Modulus ¹	2480	MPa	ISO 178
Flexural Stress	73.2	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ²			ISO 180/1A
-40°C	6.2	kJ/m ²	ISO 180/1A
-30°C	8.2	kJ/m ²	ISO 180/1A
23°C	23	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 64.0 mm Span)	82.0	°C	ISO 75-2/Af
Vicat Softening Temperature	98.2	°C	ISO 306/B50
Linear thermal expansion coefficient			ISO 11359-2
Flow: -40 to 40°C	6.0E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	6.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	

Suggested Shot Size	50 - 70	%
Rear Temperature	216 - 229	°C
Middle Temperature	232 - 243	°C
Front Temperature	249 - 268	°C
Nozzle Temperature	254 - 279	°C
Processing (Melt) Temp	254 - 279	°C
Mold Temperature	37.8 - 82.2	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	30 - 60	rpm
Vent Depth	0.038 - 0.051	mm

NOTE

1. 2.0 mm/min
2. 80*10*4
3. 80*10*4 mm

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