

CYCOLAC™ MG47U resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

Multi-purpose, UV stabilized injection molding ABS providing a favorable balance of engineering properties.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	17	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	45.0	MPa	ISO 527-2/50
Fracture	33.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	2.4	%	ISO 527-2/50
Fracture	20	%	ISO 527-2/50
Flexural Modulus ¹	2250	MPa	ISO 178
Flexural Stress	68.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ²			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	20	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	94.0	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	80.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ³	81.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	99.0	°C	ASTM D1525 ⁴
--	98.0	°C	ISO 306/B50

--	100	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (240°C, 1000 sec ⁻¹)	225	Pa·s	ASTM D3835
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	0.10	%	
Suggested Shot Size	50 - 70	%	
Rear Temperature	188 - 210	°C	
Middle Temperature	204 - 227	°C	
Front Temperature	216 - 238	°C	
Nozzle Temperature	218 - 260	°C	
Processing (Melt) Temp	218 - 260	°C	
Mold Temperature	48.9 - 71.1	°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		
4.	标准 B (120°C/h), 载荷2 (50N)		

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