

CYCOLAC™ MG94 resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

Superior flow, injection molding ABS. Good impact. For thin-wall applications.

General Information			
UL YellowCard	E45329-102071280		
Features	Impact resistance, good		
	High liquidity		
Uses	Thin wall parts		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	39.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	0.16	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	129		ISO 2039-2
Ball Indentation Hardness (H 358/30)	95.7	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/1
Tensile Stress			
Yield	40.0	MPa	ISO 527-2/5
Yield	45.0	MPa	ISO 527-2/50
Fracture	35.0	MPa	ISO 527-2/5, ISO 527-2/50
Tensile Strain			
Yield	2.0	%	ISO 527-2/5
Yield	2.2	%	ISO 527-2/50
Fracture	35	%	ISO 527-2/5
Fracture	45	%	ISO 527-2/50
Flexural Modulus ²	2450	MPa	ISO 178
Flexural Stress	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	23	kJ/m ²	ISO 179/1eA

Notched Izod Impact ⁴			ISO 180/1A
-30°C	7.5	kJ/m ²	ISO 180/1A
23°C	18	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, unannealed, 100 mm span	91.0	°C	ISO 75-2/Be
1.8 MPa, unannealed, 100 mm span	80.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	99.0	°C	ISO 306/B50
--	100	°C	ISO 306/B120
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	8.7E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	8.7E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (3.20 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 - 95.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	200 - 240	°C	
Middle Temperature	220 - 260	°C	
Front Temperature	220 - 260	°C	
Nozzle Temperature	210 - 250	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	40.0 - 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4 sp=62mm		
4.	80*10*4		
5.	120*10*4 mm		

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