

SABIC CYCOLAC™ ABS GRM2600L物性表

属性	典型值	UNITS	测试手段
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	41	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	35	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	55	%	ASTM D638
Tensile Modulus, 5 mm/min	2410	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	400	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	46	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	113	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	100	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D648
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.45-0.65	%	SABIC method
Melt Flow Rate, 220°C/10.0 kgf	2.5	g/10 min	ASTM D1238
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220708	-	-
Injection Molding			
Drying Temperature	90-95	°C	
Drying Time	2-4	Hrs	
Drying Time (Cumulative)	8	Hrs	

Maximum Moisture Content	0.02	%
Melt Temperature	230-275	°C
Nozzle Temperature	230-275	°C
Front - Zone 3 Temperature	230-255	°C
Middle - Zone 2 Temperature	210-225	°C
Rear - Zone 1 Temperature	195-210	°C
Mold Temperature	50-80	°C
Back Pressure	0.3-0.7	MPa
Screw Speed	30-60	rpm
Shot to Cylinder Size	50-70	%
Vent Depth	0.038-0.051	mm

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
Roll Stack Temp - Middle	95-105	°C
Roll Stack Temp - Bottom	100-105	°C

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