

SABIC CYCOLAC™ ABS MG47U物性表

属性	典型值	UNITS	测试手段
MECHANICAL			
Hardness, Rockwell R	112	-	ASTM D785
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	33	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.4	%	ISO 527
Tensile Strain, break, 50 mm/min	20	%	ISO 527
Tensile Modulus, 1 mm/min	2500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	68	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	99	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D648
CTE, -40°C to 40°C, flow	8.82E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	8.82E-05	1/°C	ASTM E831
Vicat Softening Temp, Rate B/50	98	°C	ISO 306
Vicat Softening Temp, Rate B/120	100	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	81	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.04	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5-0.8	%	SABIC method
Melt Viscosity, 240°C, 1000 sec-1	2250	Poise	ASTM D3825
Density	1.04	g/cm ³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	17	g/10 min	ISO 1133

Injection Molding		
Drying Temperature	80-95	°C
Drying Time	2-4	Hrs
Drying Time (Cumulative)	8	Hrs
Maximum Moisture Content	0.1	%
Melt Temperature	220-260	°C
Nozzle Temperature	220-260	°C
Front - Zone 3 Temperature	215-240	°C
Middle - Zone 2 Temperature	205-225	°C
Rear - Zone 1 Temperature	190-210	°C
Mold Temperature	50-70	°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

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