

## Cycolac\* Resin Z704

## Europe-Africa-Middle East: LIMITED USE

Z704 is an industrial high efficiency opaque ABS impact modifier with a bulk density of 290 kg/m<sup>3</sup>.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	7	MPa	ISO 527
Tensile Modulus, 1 mm/min	500	MPa	ISO 527
Flexural Modulus, 2 mm/min	500	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	15	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m <sup>2</sup>	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate A/50	96	°C	ISO 306
Vicat Softening Temp, Rate B/50	74	°C	ISO 306
Vicat Softening Temp, Rate B/120	76	°C	ISO 306
PHYSICAL	Value	Unit	Standard
Density	0.99	g/cm <sup>3</sup>	ISO 1183

Source GMD, last updated:11/11/1998

### Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	220 - 260	°C
Nozzle Temperature	210 - 250	°C
Front - Zone 3 Temperature	220 - 260	°C
Middle - Zone 2 Temperature	220 - 260	°C
Rear - Zone 1 Temperature	200 - 240	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

Source GMD, last updated:11/11/1998

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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