

Cycolac* Resin 29423B

Europe-Africa-Middle East: DEVELOPMENTAL

CYCOLAC 29423B is a clear ABS extrusion grade with good impact performance, good processability and good sheet aesthetics. Good in applications utilizing color concentrates.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 5 mm/min	39	MPa	ISO 527
Tensile Stress, break, 5 mm/min	27	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	44	MPa	ISO 527
Tensile Stress, break, 50 mm/min	33	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.2	%	ISO 527
Tensile Strain, break, 5 mm/min	35	%	ISO 527
Tensile Strain, yield, 50 mm/min	3.3	%	ISO 527
Tensile Strain, break, 50 mm/min	7	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	60	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
Hardness, H358/30	82	MPa	ISO 2039-1
Hardness, Rockwell R	102	-	ISO 2039-2
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	3	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	82	°C	ISO 306
Vicat Softening Temp, Rate B/120	84	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	75	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	67	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	SABIC Method
Density	1.09	g/cm ³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	27	g/10 min	ISO 1133
Melt Volume Rate, MVR at 220°C/10.0 kg	28	cm ³ /10 min	ISO 1133

Source GMD, last updated:07/08/2002

Processing

Parameter	Value	Unit
Profile Extrusion		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs

Melt Temperature	210 - 250	°C
Barrel - Zone 1 Temperature	205 - 230	°C
Barrel - Zone 2 Temperature	210 - 240	°C
Barrel - Zone 3 Temperature	220 - 250	°C
Barrel - Zone 4 Temperature	220 - 250	°C
Hopper Temperature	60 - 80	°C
Adapter Temperature	220 - 250	°C
Die Temperature	210 - 240	°C
Calibrator Temperature	60 - 80	°C

Source GMD, last updated:07/08/2002

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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