

CYCOLACT™ RESIN EX58F

REGION AMERICAS

DESCRIPTION

High impact ABS for sheet extrusion and blow molding applications. FDA food contact compliant.

TYPICAL PROPERTY VALUES

Revision 20260509

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	39	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	30	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3.1	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	32	%	ASTM D638
Tensile Modulus, 5 mm/min	2080	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	66	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2160	MPa	ASTM D790
Hardness, Rockwell R	102	-	ASTM D785
Tensile Stress, yield, 50 mm/min	41	MPa	ISO 527
Tensile Stress, break, 50 mm/min	30	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.6	%	ISO 527
Tensile Strain, break, 50 mm/min	21	%	ISO 527
Tensile Modulus, 1 mm/min	1970	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	60	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	432	J/m	ASTM D256
Izod Impact, notched, -30°C	299	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	37	J	ASTM D3763
Izod Impact, notched 80°10'4 +23°C	35	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10'4 -30°C	23	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10'4 sp=62mm	37	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	106	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	91	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	76	°C	ASTM D648
CTE, -40°C to 40°C, flow	1.01E-04	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ASTM E831
Vicat Softening Temp, Rate B/50	95	°C	ISO 306
Vicat Softening Temp, Rate B/120	97	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80°10'4 sp=64mm	78	°C	ISO 75/Af
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Specific Gravity	1.03	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.8	%	SABIC method
Melt Viscosity, 240°C, 100 sec-1	15500	Poise	ASTM D3825
Density	1.03	g/cm³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	4	g/10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D495
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Yellow Card Link	<u>E121562-220684</u>	-	-
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
EXTRUSION BLOW MOLDING			
Drying Temperature	80 – 90	°C	
Drying Time	4 – 5	Hrs	
Drying Time (Cumulative)	24	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature (Parison)	215 – 230	°C	
Barrel - Zone 1 Temperature	205 – 225	°C	
Barrel - Zone 2 Temperature	205 – 225	°C	
Barrel - Zone 3 Temperature	205 – 225	°C	
Barrel - Zone 4 Temperature	205 – 225	°C	
Adapter - Zone 5 Temperature	210 – 230	°C	
Head - Zone 6 - Top Temperature	215 – 230	°C	
Head - Zone 7 - Bottom Temperature	215 – 230	°C	
Screw Speed	20 – 60	rpm	
Extruder Feed Zone Temperature	60 – 75	°C	
Mold Temperature	40 – 80	°C	
Die Temperature	215 – 235	°C	
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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