

**Cycolac\* Resin GHT3512**  
**Asia Pacific: COMMERCIAL**

High heat grade of ABS used for interior automotive components.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	530	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	22	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	820	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25400	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	12	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	111	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	93	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	102	°C	ASTM D 648
<b>PHYSICAL</b>			
Specific Gravity	1.06	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/5 kgf	2	g/10 min	ASTM D 1238

<sup>1</sup> Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 230C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

<sup>2</sup> Only typical data for material selection purpose. Not to be used for part or tool design.  
<sup>3</sup> This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
<sup>4</sup> Own measurement according to UL.  
<sup>5</sup> Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 [www.kedisujiao.com](http://www.kedisujiao.com)

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Melt Temperature	240 - 260	°C
Mold Temperature	60 - 80	°C

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