

**Cycolac\* Resin MG8000SR**  
**Asia Pacific: COMMERCIAL**

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	570	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	370	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	520	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	340	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	9	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	10	%	ASTM D 638
Tensile Modulus, 50 mm/min	27200	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Modulus, 5 mm/min	27000	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	780	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26500	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Shore D	78	-	ASTM D 2240
Tensile Stress, yield, 5 mm/min	50	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	56	MPa	ISO 527
Tensile Stress, break, 50 mm/min	39	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.8	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	8	%	ISO 527

<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.

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Tensile Modulus, 1 mm/min	2600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2700	MPa	ISO 178
Hardness, H358/30	100	MPa	ISO 2039-1
Hardness, Rockwell L	87	-	ISO 2039-2
Pencil Hardness test, 1kgf	HB	-	ASTM D 3363
<b>IMPACT</b>			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	6	cm-kgf/cm	ASTM D 256
Multiaxial Impact	101	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	254	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	13	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	89	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	83	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.7E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	98	°C	ISO 306
Vicat Softening Temp, Rate B/50	91	°C	ISO 306
Vicat Softening Temp, Rate B/120	92	°C	ISO 306

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2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
5) 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.

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<b>THERMAL</b>			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	87	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	77	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.06	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.7	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	25	g/10 min	ASTM D 1238
Density	1.07	g/cm <sup>3</sup>	ISO 1183
Melt Volume Rate, MVR at 220°C/10.0 kg	25	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 260°C/5.0 kg	33	cm <sup>3</sup> /10 min	ISO 1133
<b>FLAME CHARACTERISTICS</b>			
UL Compliant, 94HB Flame Class Rating (3)(4)	1.5	mm	UL 94 by GE

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	75 - 85	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	220 - 250	°C
Nozzle Temperature	220 - 240	°C
Front - Zone 3 Temperature	230 - 250	°C
Middle - Zone 2 Temperature	220 - 240	°C
Rear - Zone 1 Temperature	210 - 230	°C
Mold Temperature	40 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.051	mm

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