CYCOLOY™ RESIN XCY620HS

REGION AMERICAS

DESCRIPTION

PC/ABS, hydrolytically stable.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Instrumented Impact Total Energy, 23°C	55	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	65	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	PASSES	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	55	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	40	kJ/m²	ISO 180/1A
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	60	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	45	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	129	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	128	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	108	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Ball Pressure Test, approximate maximum	100	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	126	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	106	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.14	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Density	1.14	g/cm³	ISO 1183

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Water Absorption, 23°C/24hrs	0.3	%	ISO 62-1
Water Absorption, (23°C/sat)	0.4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	20	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	25	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+16	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+16	Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	39	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
INJECTION MOLDING			
Drying Temperature	95 – 105	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 290	°C	
Nozzle Temperature	240 – 280	°C	
Front - Zone 3 Temperature	250 – 290	°C	
Middle - Zone 2 Temperature	250 – 290	°C	
Rear - Zone 1 Temperature	230 – 260	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 90	°C	

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