



## Cycloloy\* Resin FXC630SK

Americas: COMMERCIAL

Color package may affect performance. PC+ABS, ECO-conforming flame retardant with diamond sparkle appearance.

## Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Modulus, 50 mm/min	3100	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2680	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	7	%	ISO 527
Tensile Modulus, 1 mm/min	2800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2600	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	213	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	47	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	14	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	90	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	82	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-06	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	95	°C	ISO 306
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	Value	Unit	Standard
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	13.5	g/10 min	ASTM D 1238
Density (Molded)	1.2	g/cm <sup>3</sup>	ISO 1183
Melt Volume Rate, MVR at 260°C/2.16 kg	14	cm <sup>3</sup> /10 min	ISO 1133
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-2 Flame Class Rating (3)	1.01	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating (3)	1.19	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.49	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2	mm	UL 94

Source GMD, last updated:04/11/2001

## Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs

Maximum Moisture Content	0.04	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 275	°C
Middle - Zone 2 Temperature	220 - 265	°C
Rear - Zone 1 Temperature	220 - 255	°C
Mold Temperature	60 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

Source GMD, last updated:04/11/2001

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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