

# CYCOLOY™ FR RESIN CY8630

REGION ASIA

## DESCRIPTION

PC+ ABS Automotive applications

## TYPICAL PROPERTY VALUES

Revision 20180402

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	50	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	75	%	ASTM D 638
Tensile Modulus, 5 mm/min	2250	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	87	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	58	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.2	%	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	2250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	600	J/m	ASTM D 256
Izod Impact, notched, -30°C	300	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	90	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	90	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	50	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	25	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	50	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	25	kJ/m <sup>2</sup>	ISO 179/1eA

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	131	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	128	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°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	8.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	133	°C	ISO 306
<b>PHYSICAL</b>			
Specific Gravity	1.12	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 – 0.7	%	SABIC method
Density	1.12	g/cm <sup>3</sup>	ISO 1183
Water Absorption, 23°C/24hrs	0.3	%	ISO 62-1
Water Absorption, (23°C/sat)	0.6	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+16	Ohm-cm	IEC 60093
<b>INJECTION MOLDING</b>			
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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