

Cycoloy* Resin CX7510 Americas: COMMERCIAL

Cycoloy* CX7510 resin is an injection moldable, flame retardant PC/ABS blend, with non-chlorinated & non-brominated flame retardants. Key features of Cycoloy CX7510 resin include high heat, high flow and good impact resistance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	36	%	ASTM D 638
Tensile Modulus, 50 mm/min	26300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23700	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	64	MPa	ISO 527
Tensile Stress, break, 50 mm/min	48	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	36	%	ISO 527
Tensile Modulus, 1 mm/min	2540	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	99	MPa	ISO 178
Flexural Modulus, 2 mm/min	2620	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	65	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	662	cm-kgf	ASTM D 3763
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	36	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	113	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	106	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.9E-05	1/°C	ASTM E 831

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

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.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	115	°C	ISO 306
Vicat Softening Temp, Rate B/120	118	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	95	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.18	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.56 - 0.63	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	16	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	45	g/10 min	ASTM D 1238
Density	1.18	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.11	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.05	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	41	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VB Rating (3)	1.5	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	270 - 300	°C
Nozzle Temperature	265 - 300	°C
Front - Zone 3 Temperature	265 - 300	°C
Middle - Zone 2 Temperature	260 - 300	°C
Rear - Zone 1 Temperature	260 - 300	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.038 - 0.076	mm

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