

Cyccoloy* Resin FXC630SK
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	600	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	470	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	20	%	ASTM D 638
Tensile Modulus, 50 mm/min	31600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	960	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	27400	kgf/cm ²	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			
Izod Impact, notched, 23°C	21	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	483	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
THERMAL			
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

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

备注：以上原料物性数据由厂家发布，我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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THERMAL			
CTE, -40°C to 40°C, xflow	7.2E-05	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			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	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 ³	ISO 1183
Melt Volume Rate, MVR at 260°C/2.16 kg	14	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
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

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PROCESSING PARAMETERS	TYPICAL 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

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