

**Cycolac\* Resin FXS680GL**  
**Asia Pacific: COMMERCIAL**

Clear ABS in visual effect tints.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	400	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	280	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	36	%	ASTM D 638
Tensile Modulus, 5 mm/min	19600	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	660	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	20300	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	276	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	97	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	83	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	72	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.06E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.06E-04	1/°C	ASTM E 831
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	10	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Hot Wire Ignition (PLC)	4	PLC Code	UL 746A

<sup>1</sup> 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.

<sup>2</sup> Only typical data for material selection purpose. Not to be used for part or tool design.  
<sup>3</sup> This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
<sup>4</sup> Own measurement according to UL.  
<sup>5</sup> 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](http://www.kedisujiao.com)

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<b>ELECTRICAL</b>			
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	70 - 75	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	205 - 245	°C
Nozzle Temperature	205 - 245	°C
Front - Zone 3 Temperature	215 - 240	°C
Middle - Zone 2 Temperature	205 - 225	°C
Rear - Zone 1 Temperature	195 - 215	°C
Mold Temperature	50 - 70	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	30 - 60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.051	mm

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