



CYCOLACTM RESIN X1 1

REGION AMERICAS

DESCRIPTION

Automotive: High heat resistance. Excellent flow/impact balance. High gloss.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	42	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	33	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.6	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	27	%	ASTM D 638
Tensile Modulus, 5 mm/min	2370	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	71	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2290	MPa	ASTM D 790
Hardness, Rockwell R	104	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	46	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.6	%	ISO 527
Tensile Strain, break, 50 mm/min	18	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	69	MPa	ISO 178
Flexural Modulus, 2 mm/min	2170	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	300	J/m	ASTM D 256
Izod Impact, notched, 23°C, 6.4mm	240	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	25	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	9	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	99	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	86	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	93	°C	ASTM D 648
Vicat Softening Temp, Rate B/50	104	°C	ISO 306
Vicat Softening Temp, Rate B/120	106	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	85	°C	ISO 75/Af
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			



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 230°C/3.8 kg	3.5	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	18	g/10 min	ASTM D 1238
Melt Flow Rate, 220°C/ 10.0 kg	10	g/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220746	-	-
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	230 – 275	°C	
Nozzle Temperature	230 – 275	°C	
Front - Zone 3 Temperature	230 – 255	°C	
Middle - Zone 2 Temperature	210 – 225	°C	
Rear - Zone 1 Temperature	195 – 210	°C	
Mold Temperature	50 – 80	°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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