



Cycolac* Resin GDT2510

Americas: COMMERCIAL

Automotive. High heat resistance low gloss for unpainted interior applications. Available in custom colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	460	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	21400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22800	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	105	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	27	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	99	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	87	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	92	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.8	%	GE Method
Melt Flow Rate, 220°C/10.0 kgf	6	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	2200	poise	ASTM D 3825
OPTICAL			
Gloss, untextured, 60 degrees	25	-	ASTM D 523

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 by this or any other material under actual fire conditions.
4) Own measurement according to UL.



Cycolac* Resin GDT2510

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	95 - 100	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 255	°C
Middle - Zone 2 Temperature	225 - 240	°C
Rear - Zone 1 Temperature	200 - 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

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 by this or any other material under actual fire conditions.
4) Own measurement according to UL.