



Cycolac* Resin GHT4320

Americas: COMMERCIAL

High heat resistance with good processability. UI94 HB rated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	520	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	24600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	870	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	115	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	19	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	138	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	102	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	95	°C	ASTM D 648
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	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	GE Method
Melt Flow Rate, 220°C/10.0 kgf	8	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	2000	poise	ASTM D 3825
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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.



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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

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