



Cycoloy* Resin EHA

Americas: COMMERCIAL

PC+ABS. Electroplateable.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Modulus, 50 mm/min	2410	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	78	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2550	MPa	ASTM D 790
Hardness, Rockwell R	111	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	368	J/m	ASTM D 256
Izod Impact, notched, -30°C	64	J/m	ASTM D 256
THERMAL			
CTE, -40°C to 40°C, flow	6.3E-05	1/°C	ASTM E 831
Specific Heat	2	J/g-°C	ASTM C 351
Thermal Conductivity	0.2	W/m-°C	ASTM E 1530
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	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	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 this or any other material under actual fire conditions.
4) Own measurement according to UL.

Source, GMD, Last Update:

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 115	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	260 - 275	°C
Nozzle Temperature	245 - 260	°C
Front - Zone 3 Temperature	255 - 275	°C
Middle - Zone 2 Temperature	245 - 260	°C
Rear - Zone 1 Temperature	220 - 230	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.076	mm

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