



CYCOLOY® LG8002
Americas: **COMMERCIAL**

Automotive. Low gloss, high impact and ductility at 73F and -22F. UV-stable colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2280	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	641	J/m	ASTM D 256
Izod Impact, notched, -30°C	587	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	47	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	41	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	121	°C	ASTM D 648
HDT, 1.84 MPa, 3.2mm, unannealed	104	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.25	W/m-°C	ASTM C 177
PHYSICAL			
Specific Gravity	1.13	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 260°C/5.0 kgf	6.5	g/10 min	ASTM D 1238
OPTICAL			
Gloss, untextured, 60 degrees	30	-	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.





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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	275 - 300	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	260 - 300	°C
Middle - Zone 2 Temperature	255 - 295	°C
Rear - Zone 1 Temperature	250 - 290	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

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