



CYCOLACT™ RESIN BDT6500

REGION AMERICAS

DESCRIPTION

Automotive. Low gloss, color concentratable for interior applications. Natural only.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	48	MPa	ASTM D638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	72	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	186	J/m	ASTM D256
Falling Dart Impact (D 3029), 23°C	42	J	ASTM D3029
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	93	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	81	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	85	°C	ASTM D648
CTE, -40°C to 60°C, flow	1.55E-04	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.05	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 230°C/3.8 kg	3.3	g/ 10 min	ASTM D1238
Melt Viscosity, 260°C, 1000 sec-1	1550	Poise	ASTM D3825
Spiral Flow, 260°C, 10 ips, 3.175 X 1524 mm	863.6	mm	-
OPTICAL			
Gloss, untextured, 60 degrees	25	-	ASTM D523
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	220 – 255	°C	
Middle - Zone 2 Temperature	210 – 250	°C	
Rear - Zone 1 Temperature	195 – 240	°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	