



Cycolac* Resin CRT3370

Europe-Africa-Middle East: COMMERCIAL

CYCOLAC CRT3370 is a 17% glass reinforced injection moulding grade of ABS. It exhibits high rigidity and excellent dimensional stability combined with medium/high heat performance and good flow characteristics. It is

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	35	mg/1000cy	SABIC Method
Tensile Stress, break, 5 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	67	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 50 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	5100	MPa	ISO 527
Flexural Stress, break, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	4700	MPa	ISO 178
Hardness, H358/30	120	MPa	ISO 2039-1
Hardness, Rockwell R	117	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, xflow	4.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Ball Pressure Test, approximate maximum	100	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	101	°C	ISO 306
Vicat Softening Temp, Rate B/120	103	°C	ISO 306



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THERMAL			
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	101	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	96	°C	ISO 75/Ae
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			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.3 - 0.6	%	SABIC Method
Density	1.17	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Flow Rate, 220°C/10.0 kg	14	g/10 min	ISO 1133
Melt Volume Rate, MVR at 220°C/10.0 kg	14	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	35	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	26	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.6	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.004	-	IEC 60250
Dissipation Factor, 1 MHz	0.008	-	IEC 60250
Comparative Tracking Index	450	V	IEC 60112
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	2.5	mm	UL 94



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FLAME CHARACTERISTICS Glow Wire Flammability Index 650°C, passes at	3.2	mm	IEC 60695-2-12



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	230 - 260	°C
Nozzle Temperature	220 - 250	°C
Front - Zone 3 Temperature	230 - 260	°C
Middle - Zone 2 Temperature	230 - 260	°C
Rear - Zone 1 Temperature	220 - 250	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C



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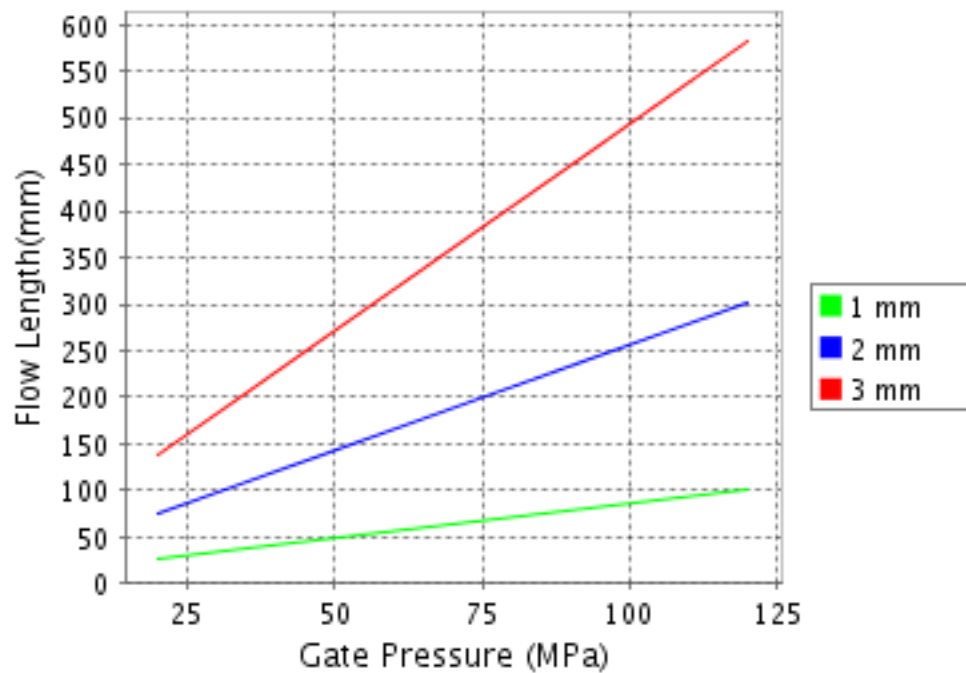
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

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Melt Temperature : 240°C

Mold Temperature : 60°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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