



Cycolac* Resin GHT3510

Americas: COMMERCIAL

Automotive. High Heat family. High impact/intermediate heat resistance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	460	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	22400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	790	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24600	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	109	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	24	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	106	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	92	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
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	4.5	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	2250	poise	ASTM D 3825



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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