

**Cyccoloy\* Resin EHA**  
**Americas: COMMERCIAL**

PC+ABS. Electroplateable.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	460	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Modulus, 50 mm/min	24600	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	800	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26000	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell R	111	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 23°C	37	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	6	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
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
<b>PHYSICAL</b>			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
<b>ELECTRICAL</b>			
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
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

<sup>1</sup> Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 230C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

<sup>2</sup> Only typical data for material selection purpose. Not to be used for part or tool design.  
<sup>3</sup> This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
<sup>4</sup> Own measurement according to UL.  
<sup>5</sup> Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 [www.kedisujiao.com](http://www.kedisujiao.com)

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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Plastics™



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
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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