

Cycoloy* Resin XCY620
Americas: COMMERCIAL

PC+ ABS Automotive applications, High Impact and High Flow, ductility at low temperature, excellent properties retention after Hydrolytic and Heat Aging

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	530	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	115	%	ASTM D 638
Tensile Modulus, 5 mm/min	23400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	900	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	51	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	115	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	83	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	65	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	48	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	571	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	713	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	70	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	45	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 +23°C	55	kJ/m ²	ISO 180/1A

¹ 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.

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 this or any other material under actual fire conditions.
⁴ Own measurement according to UL.
⁵ 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.

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IMPACT			
Izod Impact, notched 80*10*4 -30°C	45	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	45	kJ/m ²	ISO 179/1eA
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	60	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	45	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	127	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	107	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	Pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	127	°C	ISO 306
Vicat Softening Temp, Rate B/120	129	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	126	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.14	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	22	g/10 min	ASTM D 1238
Density	1.14	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.4	%	ISO 62

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	18	cm ³ /10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	195	Pa-s	ISO 11443
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	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	240 - 280	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	250 - 290	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 90	°C

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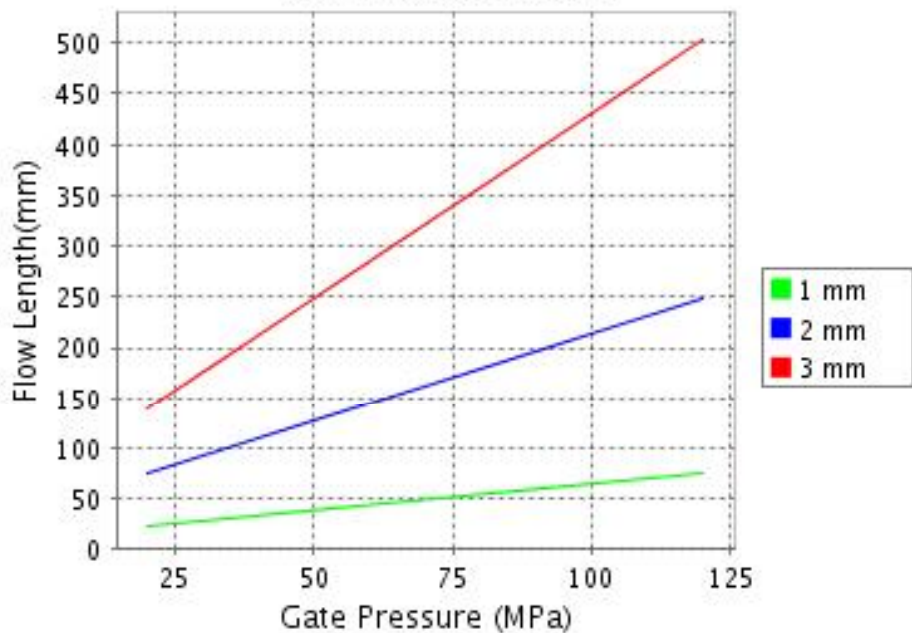
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
Cycology* XCY620
Melt Temperature : 265°C
Mold Temperature : 75°C



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

® Moldflow is a registered trademark of the Moldflow Corporation.

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