

Cycolac* Resin BDT5510
Americas: COMMERCIAL

Automotive. High heat resistance, low gloss, color concentratable for interior applications. Natural only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	540	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	23200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	820	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	29	cm-kgf/cm	ASTM D 256
Falling Dart Impact (D 3029), 23°C	359	cm-kgf	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	97	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	86	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	89	°C	ASTM D 648
CTE, -40°C to 60°C, flow	1.35E-04	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	6	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	1630	poise	ASTM D 3825
Spiral Flow, 260°C, 10 ips, 3.175 X 1524 mm	736.6	mm	-
OPTICAL			
Gloss, untextured, 60 degrees	25	-	ASTM D 523

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.

如需要更多物性资料请查阅 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！

SABIC
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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90 - 95	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
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

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