

Cycolac* Resin KJW

Americas: LIMITED USE

Molding grade FRABS

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	41	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2060	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2270	MPa	ASTM D 790
Hardness, Rockwell R	99	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	213	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	90	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.12E-04	1/°C	ASTM E 831
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			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	4	g/10 min	ASTM D 1238
OPTICAL			
Gloss, untextured, 60 degrees	96	-	ASTM D 523
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.47	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.79	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED
Oxygen Index (LOI)	29	%	ASTM D 2863
Radiant Panel Flame Spread Index	65	mm	ASTM E 162
Radiant Panel Listing	YES	-	UL Tested
UV-light, water exposure/immersion	F2	-	UL 746C

Source GMD, last updated:12/29/1999

Processing

Parameter

Injection Molding	Value	Unit
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	6	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	195 - 230	°C
Nozzle Temperature	195 - 230	°C
Front - Zone 3 Temperature	210 - 220	°C
Middle - Zone 2 Temperature	200 - 210	°C
Rear - Zone 1 Temperature	170 - 180	°C
Mold Temperature	50 - 70	°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

Source GMD, last updated:12/29/1999

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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