

Cyclocoly* Resin EXCY0025
Americas: COMMERCIAL

Recycle Material with PC+ABS+EXL recycle for good low temperature impact performance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	450	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	440	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	90	%	ASTM D 638
Tensile Modulus, 50 mm/min	22100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	20500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	44	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Flexural Stress, yield, 2 mm/min	71	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	54	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	458	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	458	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	479	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	47	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	41	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	55	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	44	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	119	°C	ASTM D 648

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/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！

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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	98	°C	ASTM D 648
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	120	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	100	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.13	-	ASTM D 792
Melt Flow Rate, 260°C/5.0 kgf	9	g/10 min	ASTM D 1238
Density	1.13	g/cm ³	ISO 1183

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	275 - 300	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	260 - 300	°C
Middle - Zone 2 Temperature	255 - 295	°C
Rear - Zone 1 Temperature	250 - 290	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

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