

**Cycology\* Resin XCY630**  
**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 <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	550	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	540	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	23400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	900	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23400	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	53	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	60	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	43	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	560	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	683	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	65	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	30	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m <sup>2</sup>	ISO 179/1eA

<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 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.

<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.

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>IMPACT</b>			
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	30	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	126	°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	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.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	126	°C	ISO 306
Vicat Softening Temp, Rate B/120	127	°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
<b>PHYSICAL</b>			
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	26	g/10 min	ASTM D 1238
Density	1.14	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	22	cm <sup>3</sup> /10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	170	Pa-s	ISO 11443
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093

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<b>ELECTRICAL</b>			
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
<b>Injection Molding</b>		
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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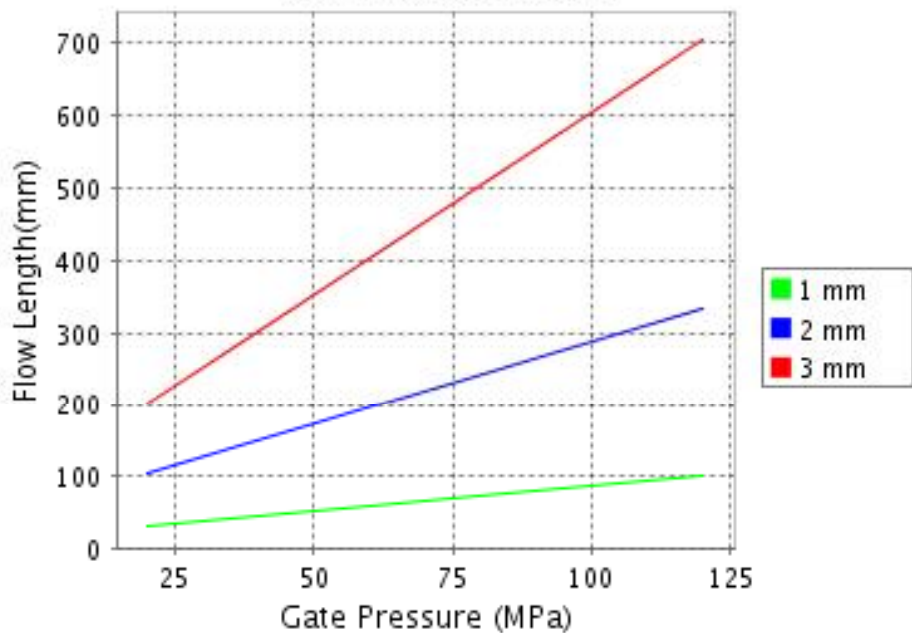
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**CALCULATED FLOW LENGTH INDICATION**  
**Moldflow® Radial Flow Analysis**  
**Cyclocoly\* XCY630**  
**Melt Temperature : 290°C**  
**Mold Temperature : 75°C**



**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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