

Cycolac* Resin MGX620ST

Europe-Africa-Middle East: COMMERCIAL

Cycolac MGX620ST is a high heat magix product with stone effect. Cycolac MGX620ST exhibits an outstanding property balance, a good flow, high heat resistance and an excellent stability during injection moulding.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	70	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	40	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	10	%	ISO 527
Tensile Modulus, 1 mm/min	2500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
Hardness, H358/30	93	MPa	ISO 2039-1
Hardness, Rockwell R	109	-	ISO 2039-2
IMPACT			
Izod Impact, notched 80*10*4 +23°C	12	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.E-05	1/°C	ISO 11359-2

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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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	106	°C	ISO 306
Vicat Softening Temp, Rate B/120	108	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	93	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	83	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.4 - 0.7	%	SABIC Method
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Flow Rate, 220°C/10.0 kg	8	g/10 min	ISO 1133
Melt Volume Rate, MVR at 220°C/10.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.011	-	IEC 60250
Dissipation Factor, 1 MHz	0.014	-	IEC 60250
Comparative Tracking Index	575	V	IEC 60112
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	1.6	mm	UL 94 by GE
Glow Wire Flammability Index 650°C, passes at	3.2	mm	IEC 60695-2-12
Glow Wire Flammability Index 750°C, passes at	1	mm	IEC 60695-2-12

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	250 - 280	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	250 - 280	°C
Middle - Zone 2 Temperature	250 - 280	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

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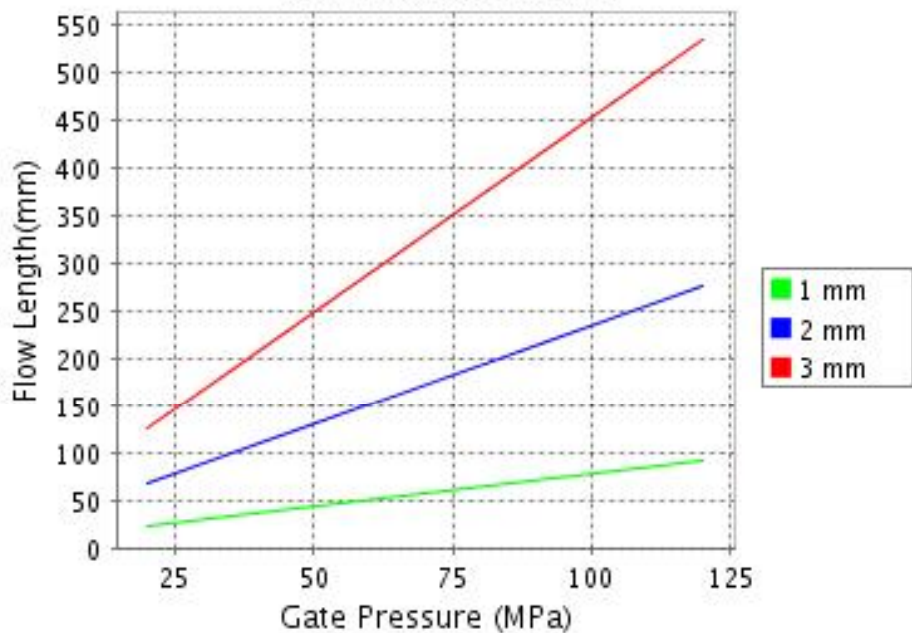
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
Cycolac* MGX620ST
Melt Temperature : 260°C
Mold Temperature : 60°C



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