

**Cycoloy\* Resin EXCY0183**  
**Americas: COMMERCIAL**

Low Gloss Cycoloy. Available only in natural, to be custom color concentrated and UV stabilized at the molding press.

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	4.6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	23200	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	860	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23200	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	52	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.3	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2390	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	83	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	65	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	39	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	581	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	642	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	54	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	32	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	63	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.

如需要更多物性资料请查阅 [www.kedisujiao.com](http://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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<b>IMPACT</b>			
Charpy Impact, notched, -30°C	30	kJ/m <sup>2</sup>	ISO 179/2C
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	123	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	126	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	103	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.6E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	123	°C	ISO 306
Vicat Softening Temp, Rate B/120	125	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	101	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.13	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	18	g/10 min	ASTM D 1238
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.39	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	20	cm <sup>3</sup> /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	240 - 290	°C
Nozzle Temperature	240 - 290	°C
Front - Zone 3 Temperature	240 - 290	°C
Middle - Zone 2 Temperature	240 - 285	°C
Rear - Zone 1 Temperature	240 - 275	°C
Hopper 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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