

Cycoloy* Resin C6600

Americas: COMMERCIAL

Nonbrominated, nonchlorinated FR PC+ABS with balanced flow, impact and hydrolytic stability for a wide variety of applications including business equipment, monitors, enclosures, among others.

PropertyImproved Flow/Impact BalanceCX7211 InfoAdditional InfoTYPICAL PROPERTIES (1)BalanceRelational BalanceRelational InfoMECHANICALValue/MProved/IH CARPENDERVED/INFOCX725ter/Additional InfoRelational InfoTensile Stress, yid, Type I, 50 mm/min40MPaASTM D 638Tensile Strain, brk, Type I, 50 mm/min40MPaASTM D 638Tensile Strain, brk, Type I, 50 mm/min80%ASTM D 638Tensile Strain, brk, Type I, 50 mm/min80%ASTM D 638Tensile Modulus, 50 mm/min80%ASTM D 638Tensile Strain, brk, Type I, 50 mm/min3000MPaASTM D 780Flexural Strass, yid, 1.3 mm/min, 50 mm span94MPaASTM D 780Flexural Strass, yid, 1.3 mm/min, 50 mm span2620MPaASTM D 780Instrumented Impact Total Energy, 23°C51JASTM D 5763Instrumented Impact Total Energy, 23°C51JASTM D 783Instrumented Impact Total Energy, 30°C51JASTM D 648HDT, 1.82 MPa, 3.2mm, unannealed99°CASTM D 648HDT, 1.82 MPa, 6.4 mm, unannealed90°CASTM D 648HDT, 1.82 MPa, 3.2mm, unannealed90°CUL 746BHDT, 1.82 MPa, 6.4 mm, unannealed90°CUL 746BHDT, 1.82 MPa, 3.2mmASTM D 638°CUL 746BHDT, 1.82 MPa, 3.2mmASTM D 638°CUL 746BHDT, 1.82 MPa, 3.2mmASTM D 638°C <t< th=""><th></th><th>Enhance</th><th>ed Property</th><th>interested in: Data Sheet</th></t<>		Enhance	ed Property	interested in: Data Sheet
TYPICAL PROPERTIES ⁽¹⁾ Balance LMTHU mice MECHANICAL ValueProvedUML 632 CV7_Standsrällonal 633 Tensile Stress, yid, Type I, 50 mm/min 43 MPa ASTM P038 Tensile Stress, brk, Type I, 50 mm/min 44 % ASTM D 638 Tensile Strain, yid, Type I, 50 mm/min 40 MPa ASTM D 638 Tensile Strain, yid, Type I, 50 mm/min 800 % ASTM D 638 Tensile Modulus, 50 mm/min 3000 MPa ASTM D 638 Flexural Stress, yid, 1.3 mm/min, 50 mm span 94 MPa ASTM D 790 IMPACT Value Unit Standard Izod Impact, notched, 23°C 550 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 51 J ASTM D 3763 Instrumented Impact Total Energy, 23°C 51 J ASTM D 3763 THERMAL Value Unit Standard Vical Softening Temp, Rate B/50 99 °C ASTM D 648 HDT, 142 MPa, 3.2mm, nannealed 80 °C ASTM D 648 HDT, 142 MPa, 6.4 mm, unannealed 90 °C UL 746B Relative Temp Index, Mech w/impact 70 °C UL 746B Relative Temp Index, Mech w/impact 0.11 % <t< th=""><th>Property</th><th>Ba</th><th>lance</th><th>Into</th></t<>	Property	Ba	lance	Into
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UL Recognized, 94-5VB Rating (3)	2	mm	UL 94
		Source GM	D, last updated:07/25/2005

Processing

Parameter		
Injection Molding	Value	Unit
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 275	°C
Middle - Zone 2 Temperature	220 - 275	°C
Rear - Zone 1 Temperature	220 - 255	°C
Mold Temperature	60 - 80	°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

Source GMD, last updated:07/25/2005

• NOTE: Back Pressure, Screw Speed, Shot to Cylinder Size and Vent Depth are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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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