

Cyclics® C65

Polybutylene Terephthalate

Cyclics Corporation

Message:

Cyclics C65 is a highly filled mineral tooling material for higher temperatures, resulting in superior quality finish on carbon fiber components. Responding to industry demand, Cyclics developed C65, a unique thermoplastic that provides dust-free, high-speed machining and a self-releasing, higher quality surface finish than alternative products. Machinists will see instant time savings with pattern-to-part applications.

Features:

- Easy machinability
- Excellent surface finish
- High heat distortion temperature
- No residual stress

Applications:

C65 can be used in a wide variety of tooling applications, including VARTM, RTM, RIM, injection molding and the production of high-quality carbon fiber parts. Cyclics recommends performing validation trials to evaluate performance in your specific application.

General Information			
Features	Excellent appearance		
	Workability, good		
	Thermal stability, good		
Uses	Thermoforming Applications		
	Mould		
Appearance	brownish yellow		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.98	g/cm ³	ASTM C128
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	91		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10800	MPa	ASTM D638
Compressive Strength	124	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	210	°C	ASTM D648
CLTE - Flow (23 to 80°C)	4.2E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (25°C)	1.6	W/m/K	ASTM D5470
Injection instructions			

Cutter: 2-3 Flute Tungsten CarbideSpeed: 3,000-20,000 RPMCut Depth: 65 mm MaxFeed: <8 m/min

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Recommended distributors for this material

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