

CYCOLOY™ XCY620HS resin

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

PC/ABS, hydrolytically stable.

General Information			
Features	Hydrolysis stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR)			ISO 1133
260°C/5.0 kg	20.0	cm ³ /10min	ISO 1133
265°C/5.0 kg	25.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.70	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.30	%	ISO 62
Saturated, 23°C	0.40	%	ISO 62
Equilibrium, 23°C, 50% RH	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	54.0	MPa	ISO 527-2/50
Fracture	56.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.5	%	ISO 527-2/50
Fracture	100	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ¹	2300	MPa	ASTM D790
-- ²	2200	MPa	ISO 178
Flexural Stress			
--	82.0	MPa	ISO 178
Yield, 50.0mm span ³	86.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴			ISO 179/1eA
-30°C	45	kJ/m ²	ISO 179/1eA
23°C	60	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength ⁵ (23°C)	No Break		ISO 179/1eU
Notched Izod Impact ⁶			ISO 180/1A
-30°C	40	kJ/m ²	ISO 180/1A
23°C	55	kJ/m ²	ISO 180/1A
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	65.0	J	ASTM D3763
23°C, Total Energy	55.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	128	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁷	126	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	108	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁸	106	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	129	°C	ASTM D1525 ⁹
--	130	°C	ISO 306/B120
Ball Pressure Test			
75°C	Pass		IEC 60695-10-2
100°C ¹⁰	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			
Flow: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+16	ohms	IEC 60093
Volume Resistivity	> 1.0E+16	ohms · cm	IEC 60093
Dielectric Strength			
0.800mm, in oil	39	kV/mm	IEC 60243-1
1.60mm, in oil	25	kV/mm	IEC 60243-1
3.20mm, in oil	17	kV/mm	IEC 60243-1
Injection	Nominal Value	Unit	
Drying Temperature	95 - 105	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60 - 80	°C	
Rear Temperature	230 - 260	°C	
Middle Temperature	250 - 290	°C	
Front Temperature	250 - 290	°C	
Nozzle Temperature	240 - 280	°C	
Processing (Melt) Temp	260 - 290	°C	
Mold Temperature	60 - 90	°C	
NOTE			

1.	1.3 mm/min
2.	2.0 mm/min
3.	1.3 mm/min
4.	80*10*4 sp=62mm
5.	80*10*3 sp=62mm
6.	80*10*4
7.	80*10*4 mm
8.	80*10*4 mm
9.	标准 B (120°C/h), 载荷2 (50N)
10.	Approximate maximum

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