



Cycolac* Resin FXS600AR

Europe-Africa-Middle East: COMMERCIAL

Visual Ares effect Cycolac ABS material with excellent flow properties.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	43	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2	%	ISO 527
Tensile Strain, break, 50 mm/min	28	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	66	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	11	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -40°C to 40°C, flow	9.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	95	°C	ISO 306
Vicat Softening Temp, Rate B/120	98	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	80	°C	ISO 75/Af
PHYSICAL			
Density	1.08	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	10	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 220°C/10.0 kg	33	cm ³ /10 min	ISO 1133

(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.

(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.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	220 - 260	°C
Nozzle Temperature	210 - 250	°C
Front - Zone 3 Temperature	220 - 260	°C
Middle - Zone 2 Temperature	220 - 260	°C
Rear - Zone 1 Temperature	200 - 240	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

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